



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15488	28/45
2	Machined By		V. T. L. H/c Shop	Dr. H. 12.0.05.2
3	Pallet Die No.		14508 (4.0) H/c	Rev. 200
4	Die Category	Drg. No.	M. 70m 60	
5	Out Side Diameter	Drg. No.	690 H/c, Step 00, 693 H/c	Tapping 12
6	Inside Diameter	Drg. No.	600.14 H/c	Step length 20 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	Under cut 1.4 H/c
8	Grooves as per Drawing	Drg. No.	12-1077.5 H/c / 12-1077.5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		640 H/c	off hole 12
13	Tapping Hole Diameter		H20, Check by H20 Roll	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 220.4 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw 17/7/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	OK						Raw. 31
2	External Relief Dia	4.5 H/c	Outside (3-3)		Inner			
3	External Relief Depth		21 H/c		17 H/c			
4	Inspection Done Before Hardening By (Name)							Raw!
5	Material Sent For Hardening By (Name)							Lark Porridge
6	Material Sent For Hardening On Date		17	7	25			

Inspected By (Sign) & Date

Raw: 18/7/25

Reviewed by (Engineer-CNC)

Manager-QA