



Lark Engineering Company (India) Pvt. Ltd.

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

10376

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.			
2	Machined By		15581 ✓	40/45 ✓
3	Pallet Die No.		V.T.L. H/c Shop	Dy No. 1.5.9.1494 ✓
4	Die Category	Drg. No.	15875(3.5) ✓	Rev. 00 ✓
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	510mm ✓	Step 02: 490.9mm ✓
7	Width of Pellet Die	Drg. No.	420.14mm ✓	Step length 27 ✓
8	Grooves as per Drawing	Drg. No.	158mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm / 12x8x3mm ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		454mm ✓	Tapping No. of Holes 8
14	Tapping On Second Side	Half pitch of 1st side	H200 Check by H200 Ball ✓	Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 18.3mm ✓	Tapping Depth 216.4 ✓
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

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

1	Counter Sinking Depth & Finish	ok								Counter 60
2	External Relief Dia	4.0mm	Outside 2.25		Inner					Rev 22
3	External Relief Depth		12mm		5mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Porrace
6	Material Sent For Hardening On Date		28	7	25					

Inspected By (Sign) & Date

										Ravi: 28/7/25
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Reviewed by (Engineer-CNC)

Manager-QA