



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.		15235	39/50
2	Machined By		V. T. L. H/c Shop	355
3	Pallet Die No.		14697 (3.0) H/c	319
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	619.9 H/c	
6	Inside Diameter	Drg. No.	52.14 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	Step length 19.5
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20. Check by H20 R. L	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 30/7/25

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 - 2 Holes Closed

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	3.5 H/c	Outside (3.3)		Inner				Ravi 38
3	External Relief Depth		17 H/c		11 H/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		30	7	25				

Inspected By (Sign) & Date

Ravi 30/7/25

Reviewed by (Engineer-CNC)

Manager-QA