



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.		15622	40/50
2	Machined By		V.T.L. H/c Shop	Dr H. 120.419
3	Pallet Die No.		14575 (4.0) H/c	Rev. 100
4	Die Category	Drg. No.	H. 70 mm	
5	Out Side Diameter	Drg. No.	70 mm Step 002 692 H/c	Step length 19.2
6	Inside Diameter	Drg. No.	600.14 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H/c / 12.5 x 8 x 7 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		845 H/c	of holes 12
13	Tapping Hole Diameter		H20. Check by H20 B-11	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.4 H/c	Tapping Depth 20.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 6/8/25	
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				
1	Counter Sinking Depth & Finish	OK		Counter: 60
2	External Relief Dia	4.5 H/c	Sub side (3-3)	Rev: 39
3	External Relief Depth		14 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ferrace	
6	Material Sent For Hardening On Date		6 8 25	
Inspected By (Sign) & Date			Ravi 6/8/25	

Reviewed by (Engineer-CNC)

Manager-QA