



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		15666	39/50/
2	Machined By		V. T. L. H/c Shop	Drg No. 1.25.978
3	Pallet Die No.		15394 (3.5) H/c	Rev. 1.00
4	Die Category	Drg. No.	Part 200 side	
5	Out Side Diameter	Drg. No.	619.9 H/c	Step 002
6	Inside Diameter	Drg. No.	520.14 H/c	Tapper 12°
7	Width of Pellet Die	Drg. No.	222 H/c	Step length 18.5
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
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 Ball	Tapping of holes 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 7/8/25

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 Sink
2	External Relief Dia	4.0 H/c	20.8 H/c	23-35	inner			Raw: 25
3	External Relief Depth		19 H/c		11 H/c			
4	Inspection Done Before Hardening By (Name)							Raw: 7/8/25
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		7	8	25			

Inspected By (Sign) & Date

Raw: 7/8/25

Reviewed by (Engineer-CNC)

Manager-QA