



Lark Engineering Company (India) Pvt. Ltd.

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

10448

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		15681	50/50
3	Pallet Die No.		V.T.L. H/O Shop	Drg. No. 12.402
4	Die Category	Drg. No.	15609(8.0) H/O	Rev. 00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	52mm, Step 00.491 H/O	Step length 7.5
7	Width of Pellet Die	Drg. No.	42.14mm	
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		H/O Shop	
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		0.031" - Check by 0.031" Ball	Tapping H.O. of holes 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4mm	Tapping Depth 16.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/8/25

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

Counter: 60

1	Counter Sinking Depth & Finish	OK								Ravi 12
2	External Relief Dia	8.5mm	outside (2.2)		Inner					
3	External Relief Depth		5mm		Nil					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Purchase
6	Material Sent For Hardening On Date			8	8	25				

Inspected By (Sign) & Date

Ravi 21/8/25

8/8/25

Reviewed by (Engineer-CNC)

Manager-QA