



Lark Engineering Company (India) Pvt. Ltd.

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

10451

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.		15625	32/12/50
2	Machined By		V. T. L. H/c Shop	Dy. No. 18.0.05
3	Pallet Die No.		15392 (4.0) H/c	Revised
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/c	Step 00. 622.3 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Step length. 18 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	Under cut. 1.2 H/c
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	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		H202 Check by H20 Ball	
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

Ravi 8/8/25

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. Go
2	External Relief Dia	4.5 H/c	5.0 H/c	4.5 H/c	All Rows 2	18 H/c				Rows. 31
3	External Relief Depth			5.0 H/c	All Rows 2	8 H/c				
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Porrace					
6	Material Sent For Hardening On Date				8	8	25			
Inspected By (Sign) & Date					Ravi	8/8/25				

Saxena 8/8/25

Reviewed by (Engineer-CNC)

Manager-QA