



Lark Engineering Company (India) Pvt. Ltd.

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

10503

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.		15711	4-1001
2	Machined By		V. T. Lark Shop	Dy. 12.0.129
3	Pallet Die No.		16196(5.0) H	Re: 100
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	540 H / Step 02, 498.8	Tapper 12.0
6	Inside Diameter	Drg. No.	520.14 H	Step length 18 H
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H / 12 x 8 x 3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/A Shop	Tapping of Holes
12	Tapping PCD		454 H	Back Side
13	Tapping Hole Diameter		H20, Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.8 H	Tapping Depth 16.0
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				
1	Counter Sinking Depth & Finish		OK	Counter 17
2	External Relief Dia	51.5 H	22-25	Inner
3	External Relief Depth		25 H	20 H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Punece	
6	Material Sent For Hardening On Date		21	8 25
Inspected By (Sign) & Date			Ravi 21/8/25	

Reviewed by (Engineer-CNC)

Manager-QA