



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.		15720	40157
2	Machined By		V. T. L. w/c Shop	Dy. H. L. K. 137
3	Pallet Die No.		15413(4.5) w/c	
4	Die Category	Drg. No.	Ex-here side	
5	Out Side Diameter	Drg. No.	619.9 w/c	Step 602 611.9 w/c
6	Inside Diameter	Drg. No.	520.14 w/c	Step 19
7	Width of Pellet Die	Drg. No.	222 w/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 w/c / 13x8x5 w/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		w/c Shop	
12	Tapping PCD		565 w/c	
13	Tapping Hole Diameter		H202 Check by H20 B. L. K.	Tapping Holes of Holes 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 w/c	Tapping Depth 8.1
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						Counters 60
2	External Relief Dia	5.0 w/c	80 B side (3-3)		Inner			Ravi 21/8/25
3	External Relief Depth		15 w/c		10 w/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		21	8	25			
Inspected By (Sign) & Date								Ravi 21/8/25

Reviewed by (Engineer-CNC)

Manager-QA