



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.		15780	46/50
2	Machined By		V.T.L. H/c Shop	Dry Hole 18.0.906
3	Pallet Die No.		15427 (G.O) H/c	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/c, Step on 622.4 H/c	Tapping 12
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 H202 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.5 H/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 22/8/25	
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	6.5 H/c	Outside (2-3)	Inner
3	External Relief Depth		10 H/c	4 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Resource	
6	Material Sent For Hardening On Date		22	8 25
Inspected By (Sign) & Date			Ravi 22/8/25	

Reviewed by (Engineer-CNC)

Manager-QA