



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		15903	35/40/66
2	Machined By		V.T.L. H/o Shop	Drg No. 18.039
3	Pallet Die No.		15631 (6.0) H/o	Rever
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/o	Step 02: 693 H/o
6	Inside Diameter	Drg. No.	546.14 H/o	Step length 31 H/o
7	Width of Pellet Die	Drg. No.	195 H/o	Under cut 2.8 H/o
8	Grooves as per Drawing	Drg. No.	32x7x9.1 H/o	32x7x9.1 H/o (4x8)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side
10	Drilling Area Surface Smoothness		OK	8 H/o Deep
11	Tapping Operator		H/o Shop	Both Side
12	Tapping PCD		619 H/o	Tapping No
13	Tapping Hole Diameter		M16	of hole 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.6 H/o	Tapping Depth 31 H/o
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 30/8/25

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 30
2	External Relief Dia	6.5 H/o	7.0 H/o	6.5 H/o	All Routs 231 H/o				Rev 12
3	External Relief Depth			7.0 H/o	All Routs 231 H/o				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Purvace				
6	Material Sent For Hardening On Date				30	8	25		

Inspected By (Sign) & Date

Ravi 30/8/25

Reviewed by (Engineer-CNC)

Manager-QA