



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.		15776	40/50
2	Machined By		V. T. L. n/c Shop	Drg No. 1.25.14805
3	Pallet Die No.		15977 (4.0) n/c	Rev. 02
4	Die Category	Drg. No.	N7810	
5	Out Side Diameter	Drg. No.	701 n/c Step 00. 702.9 n/c	Tapping 14"
6	Inside Diameter	Drg. No.	600.14 n/c	Step length 15"
7	Width of Pellet Die	Drg. No.	265.6 n/c	Order cut 2 n/c
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 7 n/c / 15.3 x 8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	0.8 n/c Deep
11	Tapping Operator		n/c Shop	Both Side
12	Tapping PCD		640 n/c	Tapping n/c
13	Tapping Hole Diameter		N20, Check by N20 Bolt	of Hole 16
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 21/9/25	
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 - Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter 60
2	External Relief Dia	4.5 n/c	Outside 2-3	Row 29
3	External Relief Depth		14 n/c	10 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ravnare	
6	Material Sent For Hardening On Date		2 9 25	
Inspected By (Sign) & Date			Ravi 21/9/25	

Reviewed by (Engineer-CNC)

Manager-QA