

Lark Engineering Company (India) Pvt. Ltd.

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

10608

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.			
2	Machined By		15753	40/50/55
3	Pallet Die No.		V.7.1 n/c Shop	0.2-2.0/4.3
4	Die Category	Drg. No.	16315(4.0) n/c	Rev. 1.00
5	Out Side Diameter	Drg. No.	2nd side	
6	Inside Diameter	Drg. No.	629.9 n/c, Step 0.0. 611.9 n/c	
7	Width of Pellet Die	Drg. No.	52.14 n/c	Step length 19.5
8	Grooves as per Drawing	Drg. No.	22.2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No.
12	Tapping PCD		565 n/c	of holes 12
13	Tapping Hole Diameter		H20. Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

8/9/25

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 - 2 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter 31
2	External Relief Dia	4.5 n/c 5.0 n/c	4.5 n/c All Pans 2	11 n/c				
3	External Relief Depth		5.0 n/c All Pans 3	5 n/c				
4	Inspection Done Before Hardening By (Name)		Lark					
5	Material Sent For Hardening By (Name)		Lark					
6	Material Sent For Hardening On Date		8	9	25			

Inspected By (Sign) & Date

8/9/25

Reviewed by (Engineer-CNC)

Manager-QA