



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.		15848	40/50
2	Machined By		V.T.L. H/c Shop	Dry H. 12.0.45
3	Pallet Die No.		15767 (4.0) H/c	Revised
4	Die Category	Drg. No.	7180	
5	Out Side Diameter	Drg. No.	730 H/c	Step 002 744 H/c
6	Inside Diameter	Drg. No.	630.14 H/c	Tap 10.0
7	Width of Pellet Die	Drg. No.	290.6 H/c	Step length 10.0
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 H/c	Under cut 7 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step
10	Drilling Area Surface Smoothness		ok	0.8 H/c Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		685 H/c	Tapping H/c
13	Tapping Hole Diameter		H202 Check by H20 B.L.	of holes 1.6
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rawi 9/9/25

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

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

1	Counter Sinking Depth & Finish	ok						Counter 2.0
2	External Relief Dia	4.5 H/c	Outside (3-3)		Inner			Row 242
3	External Relief Depth		14 H/c		10 H/c			
4	Inspection Done Before Hardening By (Name)							Rawi
5	Material Sent For Hardening By (Name)							Lark Ramesh
6	Material Sent For Hardening On Date		9	9	25			

Inspected By (Sign) & Date

Rawi 9/9/25

Reviewed by 9/9/25

Reviewed by (Engineer-CNC)

Manager-QA