



Lark Engineering Company (India) Pvt. Ltd.

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

10644

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.		15897	46/51
2	Machined By		14429 (3-5) mm	Revised
3	Pallet Die No.		Medium	
4	Die Category	Drg. No.	682 mm	Step 002 Tapped 12"
5	Out Side Diameter	Drg. No.	580.14 mm	Step length 39"
6	Inside Diameter	Drg. No.	266 mm	
7	Width of Pellet Die	Drg. No.	28.5 x 6 x 12 mm	
8	Grooves as per Drawing	Drg. No.	28.5 x 6 x 12 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		630 mm	
13	Tapping Hole Diameter		116	Check by H16 Ball
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 25.4 mm	Tapping Depth 29.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Raw: 15/9/25	
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		
2	External Relief Dia	4.0 mm	22-23	Inner
3	External Relief Depth	1.2 mm	5 mm	
4	Inspection Done Before Hardening By (Name)		Raw:	
5	Material Sent For Hardening By (Name)		Lark Porcelain	
6	Material Sent For Hardening On Date		15 9 25	
Inspected By (Sign) & Date			Raw: 15/9/25	

Reviewed by (Engineer-CNC)

Manager-QA