



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.		15995	30/50
2	Machined By		V. T. L. n/c Shop	15137 (3.5) n/c
3	Pallet Die No.		2x2mm wide	Rev. no
4	Die Category	Drg. No.	619.9 n/c	Step 00. Tapper 12°
5	Out Side Diameter	Drg. No.	520.14 n/c	Step length 18.5
6	Inside Diameter	Drg. No.	222 n/c	
7	Width of Pellet Die	Drg. No.	13x8x5 n/c	
8	Grooves as per Drawing	Drg. No.	ok	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		n/c, Check by H22 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 17/9/25	
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 30°
2	External Relief Dia	4.0 n/c	20 Side 2-2	Row 35
3	External Relief Depth	23 n/c	Inner 20 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Burnace	
6	Material Sent For Hardening On Date		17 9 25	
Inspected By (Sign) & Date			Ravi 17/9/25	

Reviewed by (Engineer-CNC)

Manager-QA