

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.		16129	40/45
2	Machined By		V. T. L. H/c Shop	Drg. No. 18.0.095
3	Pallet Die No.		15882 (G.O) H/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510 H/c Shop 00.490.9 H/c	
6	Inside Diameter	Drg. No.	420.14 H/c	Shop length 13.5
7	Width of Pellet Die	Drg. No.	152 H/c	
8	Grooves as per Drawing	Drg. No.	11x5x3 H/c / 11x5x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		456 H/c	
13	Tapping Hole Diameter		0.914" - Check by 0.914" Ball	Tapping H/c of H/c 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 16.4 H/c	Tapping Depth 14.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 30/9/25

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 60
2	External Relief Dia	6.5 H/c	Outside 2.2	Inner				Rev 15
3	External Relief Depth		11 H/c	5 H/c				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		30	9	25			

Inspected By (Sign) & Date

Ravi 30/9/25

30/9/25

Reviewed by (Engineer-CNC)

Manager-QA