



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.		16183	37/40
2	Machined By		V. T. L. n/c Shop	Qty 100, 12.0.335
3	Pallet Die No.		15670(5.0) n/c	Rev 100
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c Shop 00.490.9 n/c	Step length 17
6	Inside Diameter	Drg. No.	420.144 n/c	
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	127 87 3 n/c 127 87 3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	Tapping of Holes 8
13	Tapping Hole Diameter		0.034" 2 Check by 0.034" Ball	Back Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 n/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sao: 16/10/25

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 260
2	External Relief Dia	5.5 n/c	22-2	Inner				Rev 17
3	External Relief Depth		8 n/c	3 n/c				
4	Inspection Done Before Hardening By (Name)			Sao				
5	Material Sent For Hardening By (Name)			Lark Pernare				
6	Material Sent For Hardening On Date		16	10	25			

Inspected By (Sign) & Date

Sao: 16/10/25

Reviewed by (Engineer-CNC)

Manager-QA