



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.		16345	55/60
2	Machined By		V. T. L. n/c Shop	Dry run 1-2-3-362
3	Pallet Die No.		16528 (4.0) n/c	Renew
4	Die Category	Drg. No.	7410	
5	Out Side Diameter	Drg. No.	750 n/c	Step 002 743.9 n/c Tappet 50
6	Inside Diameter	Drg. No.	630.14 n/c	Step length 23.3
7	Width of Pellet Die	Drg. No.	290.6 n/c	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 n/c / 15.3 x 8 x 5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		n/c Shop	0.8 n/c Depth Both Side
12	Tapping PCD		685 n/c	Tapping Holes
13	Tapping Hole Diameter		n/c Check by H2 Bolt	of holes 16 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/7/25

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 - 2 Hole Closed

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	4.5 n/c	Outside 83-3)		Inner			Rev 43
3	External Relief Depth		13 n/c		5 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		13	11	25			

Inspected By (Sign) & Date

Ravi 31/7/25

Reviewed by (Engineer-CNC)

Manager-QA