



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.		14878	40/40
2	Machined By		V. T. L. H/c Shop	Drg. H. L. & A. 1500
3	Pallet Die No.		14696 (4.0) H/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c	Step on 498.88
6	Inside Diameter	Drg. No.	420.12 H/c	Tabble 12
7	Width of Pellet Die	Drg. No.	158 H/c	Step length 18.5
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 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		454 H/c	Tapping H/c of holes 8
13	Tapping Hole Diameter		H202 Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Raw! 12/5/25	
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			Counter 60°
2	External Relief Dia	4.5 H/c	Outside (2.2)	Raw! 20
3	External Relief Depth		4 H/c	Inner Mill
4	Inspection Done Before Hardening By (Name)		Raw!	
5	Material Sent For Hardening By (Name)		Lark Purrace	
6	Material Sent For Hardening On Date		12/5/25	
Inspected By (Sign) & Date			Raw! 12/5/25	

Reviewed by (Engineer-CNC)

Manager-QA