



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14177/	415/55/
2	Machined By		V.T.L. H/c Shop	Drig No. 1 S.D. 1011
3	Pallet Die No.		12804 (80) H/c	Rev. 00
4	Die Category	Drg. No.	M. Tumbo	
5	Out Side Diameter	Drg. No.	740 H/c	Step OP, 733.3 H/c, Tappers, 12
6	Inside Diameter	Drg. No.	630.12 H/c	Step length 23.5
7	Width of Pellet Die	Drg. No.	250 H/c	
8	Grooves as per Drawing	Drg. No.	17x8x7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	17x8x7 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		680 H/c	Tapping No. of Holes - 12 Both Side
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 25.3 H/c	Tapping Depth 23.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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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

Counter = 600

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	8.5 H/c	90 Side (3.3)		Inner				
3	External Relief Depth		18 H/c		10 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		20	2	25				

Inspected By (Sign) & Date

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Satyam 20/2/25

Reviewed by (Engineer-CNC)

Manager-QA