



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.		14359	38/51
2	Machined By		V.T.L. H/C Shop	Drg. No. 129.537
3	Pallet Die No.		12667 (3.0) H/C	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	732 H/C, Step 002 742 H/C	Tapper 4"
6	Inside Diameter	Drg. No.	630.12 H/C	Step length 87.5
7	Width of Pellet Die	Drg. No.	255 H/C	Under cut 5.5 H/C
8	Grooves as per Drawing	Drg. No.	22x8x7 H/C / 22x8x7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of Holes 12 Both Side
12	Tapping PCD		685 H/C	
13	Tapping Hole Diameter		M22.2 Check by M22 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 28.3 H/C	Tapping Depth 26.1
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/3/25

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

Counter 60

1	Counter Sinking Depth & Finish	OK						Counter 60
2	External Relief Dia	3.5 H/C	Outside (3-3)		Inner			Rev 42
3	External Relief Depth		19 H/C		13 H/C			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		13	3	25			

Inspected By (Sign) & Date

Ravi 13/3/25

Reviewed by (Engineer-CNC)

Manager-QA