



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.		14457	30/50
2	Machined By		V.T.L. H/C Shop	Drg. No. 1.30.450
3	Pallet Die No.		13498 (3.0) H	200200
4	Die Category	Drg. No.	Jew	
5	Out Side Diameter	Drg. No.	730 H / Step 00, 743.4 H	Tap hole 1.3
6	Inside Diameter	Drg. No.	630.12 H	Step length 0.3 H
7	Width of Pellet Die	Drg. No.	290 H	Under cut 0.3 H
8	Grooves as per Drawing	Drg. No.	15x8x5 H / 15x8x5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		685 H	
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 20.2 H Tapping Depth 18.0 H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rawi 18/3/25

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

1	Counter Sinking Depth & Finish	OK							Counter 2.6
2	External Relief Dia	3.3 H	Outside 3.3		Inner				
3	External Relief Depth		2.3 H		down				
4	Inspection Done Before Hardening By (Name)								Rawi
5	Material Sent For Hardening By (Name)								Lark Forrare
6	Material Sent For Hardening On Date		18	3	25				

Inspected By (Sign) & Date

Rawi 18/3/25

Reviewed by (Engineer-CNC)

Manager-QA