



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.			
2	Machined By		14424 ✓	45/50 ✓
3	Pallet Die No.		V.T.L. H/C Shop	1 Dy No. 1.2.0.493
4	Die Category	Drg. No.	14118(5.0) H/C	Rev 2.00
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	700 H/C, Step 00. 693 H/C	Tapping 12"
7	Width of Pellet Die	Drg. No.	600.12 H/C (Bot Tapping 0.2 H/C)	Step length 28 H/C
8	Grooves as per Drawing	Drg. No.	222 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12x10x7.5 H/C 12x10x7.5 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		H 202 Check by H 202 Ball	Tapping No. of holes 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.3 H/C	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/3/25

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
Rev 2.00

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	5.5 H/C	Outside (2.3-3)		Inner		
3	External Relief Depth		10 H/C		5 H/C		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		24	3	25		

Inspected By (Sign) & Date

Ravi 24/3/25

Reviewed by (Engineer-CNC)

Manager-QA