



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.		14632	36/50
2	Machined By		N.T.C. H/o Shop	Dr. H. L. 20/9/80
3	Pallet Die No.		14459 (3.0) H	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	320.1 H	Step 00 Tapper 12°
6	Inside Diameter	Drg. No.	520.12 H	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H 13x8x5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/o Shop	Tapping H- of H. L. 12 B-side
12	Tapping PCD		565 H	
13	Tapping Hole Diameter		H20. C. back by H20 B. 12	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H	Tapping Depth 18.5
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 - 1 Hole. Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter. Boi

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.5 H	23-25		Inner				
3	External Relief Depth		20 H		14 H				
4	Inspection Done Before Hardening By (Name)				Rev:				
5	Material Sent For Hardening By (Name)				Lark R. R. R. R.				
6	Material Sent For Hardening On Date		11	4	25				

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA