



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.		14629	37/47
2	Machined By		V.T.L. H/O Shop	Dr. H. 13.0.875
3	Pallet Die No.		13848 (3.0) H/O	Rev. 00
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	614 H/O Step 00-684 H/O	Tapp. 12
6	Inside Diameter	Drg. No.	520.12 H/O 520.12 H/O	Step length 18 H/O
7	Width of Pellet Die	Drg. No.	222 H/O	Under cut = 5 H/O
8	Grooves as per Drawing	Drg. No.	13x8x5 H/O 13x8x5 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		565 H/O	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/O	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sav: 9/4/25

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 60
2	External Relief Dia	3.5 H/O	Outside (3.3)		Inner			Rev. 38
3	External Relief Depth		16 H/O		10 H/O			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date							

Inspected By (Sign) & Date

Sav: 9/4/25

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Reviewed by (Engineer-CNC)

Manager-QA