



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.		14692	35/43
2	Machined By		V.T.L. n/c. Shop	Py. n/c. 1-2-2-09
3	Pallet Die No.		14361(4.5) n/c	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	399 n/c, Step 002	383 n/c
6	Inside Diameter	Drg. No.	313.12 n/c	Step length 10 n/c
7	Width of Pellet Die	Drg. No.	142 n/c	
8	Grooves as per Drawing	Drg. No.	14x6x3.2 n/c 14x6x3.2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c. Shop	
12	Tapping PCD		352 n/c	
13	Tapping Hole Diameter		23/4" e Check by 23/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 20/4/25

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							
2	External Relief Dia	50 n/c	Outside (2-2)		Inner				
3	External Relief Depth		13 n/c		8 n/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		20	4	25				

Inspected By (Sign) & Date

Raw: 20/4/25

Reviewed by (Engineer-CNC)
20/4/25

Manager-QA