



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)

9812

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14895	39/52
2	Machined By		V.T.L. n/c Shop	By H. 1302549
3	Pallet Die No.		14240(3.0) mm	Ren 2 mm
4	Die Category	Drg. No.	H-7umbo	
5	Out Side Diameter	Drg. No.	703.9 mm	Step 00.692.8 mm
6	Inside Diameter	Drg. No.	600.12 mm	Step length 20 mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 10 x 7.5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		840 mm	
13	Tapping Hole Diameter		H20 - Check by H2 - Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.5 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 7/5/25

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 26

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 mm	Outside (3-3)		Inner				
3	External Relief Depth		19 mm		13 mm				
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

Ravi 7/5/25

Reviewed by (Engineer-CNC)

Manager-QA