



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.		14706	34/40
2	Machined By		N.T.C. H/C Shop	By H. 12.2. 146
3	Pallet Die No.		15183(2.8) H/C	Rev 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	384.8 H/C Step 002 382.8 H/C Stepleng 11.5	
6	Inside Diameter	Drg. No.	305.12 H/C	
7	Width of Pellet Die	Drg. No.	144 H/C	
8	Grooves as per Drawing	Drg. No.	107.8 x 5 H/C 107.8 x 5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		350 H/C	
13	Tapping Hole Diameter		M16: Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/C Tapping Depth 18.6 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 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 - 2 Hole Colused

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

Counters 60

1	Counter Sinking Depth & Finish	OK						Counters 60
2	External Relief Dia	3.1 H/C	Outside (2.2)		Inner			
3	External Relief Depth		12 H/C		6 H/C			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date			7	5	25		

Inspected By (Sign) & Date

Raw: 7/5/25

Reviewed by (Engineer-CNC)

Manager-QA