



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.		14850	58/66
2	Machined By		V. T. L. H/c Shop	Drg No. 12.2.32
3	Pallet Die No.		14987 (9.0) H/c	Rev. 08
4	Die Category	Drg. No.	H. 70m ho	
5	Out Side Diameter	Drg. No.	680.1 H/c	Step 00: 683 H/c
6	Inside Diameter	Drg. No.	546.12 H/c	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c	C 4 x 8
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 H/c Deep
11	Tapping Operator		H/c Shop	Back Side
12	Tapping PCD		619 H/c	Tapping No
13	Tapping Hole Diameter		H16: Check by H16 Bolt	of Hole 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Back Side
15	Tapping Hole Depth		Drill Depth 33.4 H/c	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rev: 8/5/25

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

1	Counter Sinking Depth & Finish	ok							Counter 26
2	External Relief Dia	10.0 H/c							Rev: 8
3	External Relief Depth								
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

Rev: 8/5/25

Reviewed by (Engineer-CNC)

Manager-QA