



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.		14959	31/501
2	Machined By		V. T. L. N/A Shop	Dry W. 1.2.0.14905
3	Pallet Die No.		14603 (2.8) W	Rev. 03
4	Die Category	Drg. No.	H720	
5	Out Side Diameter	Drg. No.	704 W, Step 002 Tapper 12"	
6	Inside Diameter	Drg. No.	600.14 W	Step length 17.1 W
7	Width of Pellet Die	Drg. No.	265.6 W	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 7 W / 15.3 x 8 x 7 W	Face Side Step
9	Fitting Sizes on CNC Plate	Drg. No.	OK	and 1/2 Deep
10	Drilling Area Surface Smoothness		OK	Both Side
11	Tapping Operator		N/A Shop	Tapping Holes
12	Tapping PCD		640 W	of holes 16
13	Tapping Hole Diameter		H20. Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.7 W Tapping Depth 18.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rao: 17/5/25

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 - 1 Hole Closed

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

Counter 600

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.3 W	Outside 3.3		Inner				
3	External Relief Depth		25 W		19 W				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		17	5	25				

Inspected By (Sign) & Date

Rao: 17/5/25

Reviewed by (Engineer-CNC)

Manager-QA