



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.		149813	34/44/55
2	Machined By		V. T. L. N/C Shop	Qty. 1.85.1498
3	Pallet Die No.		14047 (4.5) H	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	629.9 H	Step 00. 611.9 H
6	Inside Diameter	Drg. No.	520.14 H	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H	13x8x5 H
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		58.5 H	
13	Tapping Hole Diameter		M20	Tabbing Holes 12
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 20.3 H	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/5/25

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 20.6
2	External Relief Dia	5.0 H / 5.5 H	5.0 H	All Rows 2 21 H						Rows 29
3	External Relief Depth	-	5.5 H	All Rows 11 H						
4	Inspection Done Before Hardening By (Name)			Ravi						
5	Material Sent For Hardening By (Name)			Lark Purware						
6	Material Sent For Hardening On Date		20	5	25					

Inspected By (Sign) & Date

Ravi 20/5/25

Reviewed by (Engineer-CNC)

Manager-QA