



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.		14983	42/50
2	Machined By		V.T.L. n/c Shop	Day No. 12.9.80
3	Pallet Die No.		15118 (B.O) 44	Rev. 05
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52.3 mm, Step 00.492.4 mm	Step length 17.17
6	Inside Diameter	Drg. No.	42.14 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12.8 x 3 mm, 12.8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		33/4" = Check by 33/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19 mm	Tapping Depth 17.17
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

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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 = 6
2	External Relief Dia	6.5 mm	8.2.25		Inner					Rev. 15
3	External Relief Depth		14 mm		8 mm					
4	Inspection Done Before Hardening By (Name)									Rev:
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		28	5	25					

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA