



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)

10005

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15015	42/50
2	Machined By		N.T.L. H/c Shop	Qty No. 18.0.71
3	Pallet Die No.		14845 (4.0) mm	Revised
4	Die Category	Drg. No.	Guidance	
5	Out Side Diameter	Drg. No.	620 mm Step 00. 622.2 mm	Tapping 12
6	Inside Diameter	Drg. No.	520.14 mm	Step length 12 mm
7	Width of Pellet Die	Drg. No.	222 mm	Length cut. 1.2 mm
8	Grooves as per Drawing	Drg. No.	9x10x4 mm / 9x10x4 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		56.5 mm	of holes. 12
13	Tapping Hole Diameter		1202 Check by H/c Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 20.4 mm	Tapping Depth. 18.5 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 31/5/25

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 - 3 Hole Colused

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

Counters 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.5 mm	Outside (3-3)		Inner				
3	External Relief Depth		12 mm		8 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		31	5	25				

Inspected By (Sign) & Date

Raw: 31/5/25

Satyam

Reviewed by (Engineer-CNC)

Manager-QA