



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.		14982	4-145
2	Machined By		V. T. L. N/C Shop	By H. 1.2.14.949
3	Pallet Die No.		14512 (B.5) H	Renzo
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	509.9 H	Step on 496.9 H
6	Inside Diameter	Drg. No.	426.14 H	Step on 417.5
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H	12x8x3 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		454 H	
13	Tapping Hole Diameter		H20 = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.6 H	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rasi: 28/5/25

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
2	External Relief Dia	4.0 H	Outside 2.27		Inner			Rev: 22
3	External Relief Depth		12 H		5 H			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		28	5	25			

Inspected By (Sign) & Date

Rasi: 28/5/25

Reviewed by (Engineer-CNC)

Manager-QA