

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Inprocess Inspection (Pellet Dies)

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15055	410/55
2	Machined By		V.T.L. w/c Shop	Dy H. 12.0.1334
3	Pallet Die No.		13897 (6.0) H	Rev. 100
4	Die Category	Drg. No.	58872	
5	Out Side Diameter	Drg. No.	629.8 H, Step OD: 623.4 H	Tapping 125
6	Inside Diameter	Drg. No.	520.14 H	Step length 2 H
7	Width of Pellet Die	Drg. No.	186 H	
8	Grooves as per Drawing	Drg. No.	14x8x5 H / 14x8x5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		w/c Shop	Tapping H
12	Tapping PCD		565 H	of Holes: 12
13	Tapping Hole Diameter		H/C, 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 H	Tapping Depth: 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 30/5/25

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 Sink
2	External Relief Dia	6.5 H	20.5 H	Inner				Rev. 18
3	External Relief Depth		20 H	15 H				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		30	5	25			

Inspected By (Sign) & Date

Raw: 30/5/25

Reviewed by (Engineer-CNC)

Manager-QA