



Lark Engineering Company (India) Pvt. Ltd.

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

9989

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.		15091	36/40
2	Machined By		V.T.L. H/c Shop	Dy No. 1802905
3	Pallet Die No.		15076(3-0) H/c	Rev 1.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	50mm, Step on 49mm	Step length 17.5
6	Inside Diameter	Drg. No.	42.012 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	[Tapping H/c of H/c 8 Both Side]
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		03/4" 2 Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18mm Tapping Depth 16.8	
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

Counter = 60

1	Counter Sinking Depth & Finish	OK						Rev: 24
2	External Relief Dia	3.5 H/c	Outside 82-21	Inner				
3	External Relief Depth		10 H/c	4 H/c				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date							

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA