



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.		14998	33/4
2	Machined By		V. T. L. NLC Shop	Drg. H. 130.138
3	Pallet Die No.		14757 (3.0) H1	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	385 H1	Step 00 = 382 H1
6	Inside Diameter	Drg. No.	305.12 H1	Step length 9.5
7	Width of Pellet Die	Drg. No.	125 H1	
8	Grooves as per Drawing	Drg. No.	9x6x4.5 H1	9x6x4.5 H1
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		NLC Shop	
12	Tapping PCD		350 H1	
13	Tapping Hole Diameter		5/8" = Check by 5/8" Tap	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 16.8 H1	Tapping Depth = 17.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/5/25

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. G3
2	External Relief Dia	3.5 H1	Outside 2.25		Inner					Rev. 20
3	External Relief Depth		13 H1		7 H1					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		29	5	25					

Inspected By (Sign) & Date

Ravi 29/5/25

Reviewed by (Engineer-CNC)

Manager-QA