



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)

Remarks

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15073	Go/Go
2	Machined By		N.T.L. H/C Shop	Drill Hole 18.0.925
3	Pallet Die No.		13914(3.2)H	Rev. 00
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	639.8 H	Step 002 62.4 H
6	Inside Diameter	Drg. No.	520.14 H	Tapping 12.5
7	Width of Pellet Die	Drg. No.	222 H	Step length 21.5
8	Grooves as per Drawing	Drg. No.	13x8x5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N.T.L. Shop	
12	Tapping PCD		56.5 H	Tapping Hole of holes 12
13	Tapping Hole Diameter		H20, Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 220.4 H	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 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 - 2 hole Closed

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

Counter 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.5 H	Outside (3-3)		Inner				
3	External Relief Depth		10 H		Nil				
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

Ravi 30/5/25

Reviewed by (Engineer-CNC)

Manager-QA