



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)

9998

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15044	30/47
2	Machined By		V. T. L. H/c Shop	Qty 4, 12.0.12 33
3	Pallet Die No.		13142 (3.0) H/c	Rev. 00
4	Die Category	Drg. No.	53370	
5	Out Side Diameter	Drg. No.	614 H/c	Step 02, 623.6 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Tapping 12
7	Width of Pellet Die	Drg. No.	186 H/c	Step length 18 H/c
8	Grooves as per Drawing	Drg. No.	13x8x3 H/c	Under cut 4.8 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	
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 20.4 H/c	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

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

Counter 60°

1	Counter Sinking Depth & Finish	ok						Rev. 30
2	External Relief Dia	3.5 H/c	Outside 3-3)		Inner			
3	External Relief Depth		18 H/c		15 H/c			
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

Ravi 30/5/25

30/5/25

Reviewed by (Engineer-CNC)

Manager-QA