



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.		15142	45/5-
2	Machined By		V.T.L. H/c Shop	Dr. H. 12.0.976
3	Pallet Die No.		13253 (4.5) H/c	Rev. 01
4	Die Category	Drg. No.	SSS 70	
5	Out Side Diameter	Drg. No.	620 H/c	Step 00: 623 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Tappet: 12°
7	Width of Pellet Die	Drg. No.	186 H/c	Step length: 2mm
8	Grooves as per Drawing	Drg. No.	13x8x3 H/c	Under cut: 1.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		56.5 H/c	Tapping H/c of H. 12. 12
13	Tapping Hole Diameter		H20: Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 H/c	Tapping Depth: 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi: 5/6/25

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							
2	External Relief Dia	5.0 H/c	Outside (3-3)		Inner				
3	External Relief Depth		10 H/c		5 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		5	6	25				

Inspected By (Sign) & Date

Ravi: 5/6/25

Reviewed by (Engineer-CNC)

Manager-QA