



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.			
2	Machined By		15156 ✓	50/66
3	Pallet Die No.		V.T.L. n/c Shop	55/66
4	Die Category	Drg. No.	15212 (8.0) n/c	Dry H. 12.0.32
5	Out Side Diameter	Drg. No.	M. Jumbo	Recess
6	Inside Diameter	Drg. No.	680.1 n/c	Step 00.693 n/c
7	Width of Pellet Die	Drg. No.	546.12 n/c (130.548.2)	Step length 31 n/c
8	Grooves as per Drawing	Drg. No.	195 n/c	Under cut 2.8 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.1 n/c 32.7 x 9.1 n/c (4x8) n/c	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		ok	2 n/c Depth
12	Tapping PCD		n/c Shop	Both Side
13	Tapping Hole Diameter		619 n/c	Tapping H.
14	Tapping On Second Side	Half pitch of 1st side	n/c 2 Check by n/c Bolt	of holes 2
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.4 n/c	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

San: 31/6/25

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

1	Counter Sinking Depth & Finish	ok						Counter 30°
2	External Relief Dia	9.0 n/c	1st Pad	16 n/c	2nd Pad	11 n/c		Recess 10°
3	External Relief Depth							
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

San: 5/6/25

Reviewed by (Engineer-CNC)

Manager-QA