



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		15167	50/50
3	Pallet Die No.		V.T.L. n/c Shop	Dy n. 1-2.0.45
4	Die Category	Drg. No.	15469 (G.O.) n/c	Rev. 01
5	Out Side Diameter	Drg. No.	743.5mm	
6	Inside Diameter	Drg. No.	630.14mm	Step length 98.3
7	Width of Pellet Die	Drg. No.	290.6mm	Length cut - 6.75
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5mm	Face Side
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Step 0.8mm
10	Drilling Area Surface Smoothness		OK	Both Side
11	Tapping Operator		n/c Shop	Tapping No. of holes - 16
12	Tapping PCD		685mm	Both Side
13	Tapping Hole Diameter		H22 Clock by H22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.5mm	Tapping Depth - 18.5mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

16/6/25

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. 60
2	External Relief Dia	6.5mm	80 Side (2-3)		Inner			Var. 31
3	External Relief Depth		6mm		Nil			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		16	6	25			

Inspected By (Sign) & Date

16/6/25

Reviewed by (Engineer-CNC)

Manager-QA