



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10085

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		15017	36/42
3	Pallet Die No.		V.T.L. n/c Step	1 Dy 4.18.0.1812
4	Die Category	Drg. No.	15739(3.0) n/c	Rev: 00
5	Out Side Diameter	Drg. No.	59 n/c	
6	Inside Diameter	Drg. No.	50.4 n/c Step 00: 49.7 n/c	Step length 16.5
7	Width of Pellet Die	Drg. No.	420.14 n/c	
8	Grooves as per Drawing	Drg. No.	173 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x10x5 n/c / 12x10x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Step	
13	Tapping Hole Diameter		455 n/c	
14	Tapping On Second Side	Half pitch of 1st side	0.3 n/c 2 Check by 0.3 n/c B.1	Tapping n/c of Holes 8 Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 n/c	Tapping Depth 18.5
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Rao: 14/6/25

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 - Hole Canceled

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

Counter. Rao: 27

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5 n/c	outside 2.2 n/c		Inner		
3	External Relief Depth		12 n/c		6 n/c		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		14	6	25		

Inspected By (Sign) & Date

Rao: 14/6/25

Reviewed by (Engineer-CNC)

Manager-QA