



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.		15237	38/50
2	Machined By		N.T.L. n/c Shop	Dry H ₂ L.S.C. 998
3	Pallet Die No.		14855(2.8) n/c	Rev. 00
4	Die Category	Drg. No.	2429 wide	
5	Out Side Diameter	Drg. No.	220 n/c	Step 002 Tapper 12°
6	Inside Diameter	Drg. No.	520.14 n/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13 x 8 x 5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping H ₂ of 4-10.12
13	Tapping Hole Diameter		56.5 n/c	Both Side
14	Tapping On Second Side	Half pitch of 1st side	M20 x 2.5 Check by M20 Ball	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 n/c	Tapping Depth 18.6
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

18/6/25

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	3.2 n/c	23.5 side		Inner			Rev 40
3	External Relief Depth		18 n/c		12 n/c			
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

18/6/25

Reviewed by (Engineer-CNC)

Manager-QA