



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)

10105

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15228	28/50
2	Machined By		N.T.L. H/c Shop	Dr. H/c L.F. 1128C
3	Pallet Die No.		14314 (2.8) H/c	Rev. on
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620 H/c, Step 002 622.8 H/c	Tapper: 12"
6	Inside Diameter	Drg. No.	520.14 H/c	Under cut: 1.9 H/c
7	Width of Pellet Die	Drg. No.	186 H/c	Step Length: 18 H/c
8	Grooves as per Drawing	Drg. No.	13x8x3 H/c 13x8x3 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		565 H/c	
13	Tapping Hole Diameter		N202 Check by N20.8 H/c	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.4 H/c Tapping Depth: 18 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 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 Go
2	External Relief Dia	3.3 H/c	Outside (3-3)		Inner				Raw 231
3	External Relief Depth		25 H/c		22 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		18	6	25				

Inspected By (Sign) & Date

Raw: 18/6/25

Reviewed by (Engineer-CNC)

Manager-QA