



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.		15250/	39/55/
2	Machined By		V.T.L. n/c Shop	Dy Hse 1-3-0-4-7
3	Pallet Die No.		14276 (G.O) n/c	Rev 200
4	Die Category	Drg. No.	H-Jumbo	
5	Out Side Diameter	Drg. No.	709.9 n/c, Step 00 = 692.8 n/c	Tapping 12
6	Inside Diameter	Drg. No.	600.14 n/c	Step length 200
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x7 n/c / 12x8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holes 12
12	Tapping PCD		64 n/c	Both Side
13	Tapping Hole Diameter		H202 Check by H20 B.O.	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Saoi 23/6/25

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

Counter G.O.

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.8 mm	outside (3-3)		Inner				
3	External Relief Depth		22 mm		16 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		23	6	25				

Inspected By (Sign) & Date

Saoi 23/6/25

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Reviewed by (Engineer-CNC)

Manager-QA