



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.		15263	38/50
2	Machined By		V.T.L. n/c Shop	Dr. No. 18.018
3	Pallet Die No.		14971(5.0) n/c	Rev. 02
4	Die Category	Drg. No.	3510	
5	Out Side Diameter	Drg. No.	519.9 n/c	Step 0.2. 49 n/c
6	Inside Diameter	Drg. No.	42.14 n/c	Step length 17.0
7	Width of Pellet Die	Drg. No.	18.2 n/c	
8	Grooves as per Drawing	Drg. No.	12.8 x 3 n/c	12.8 x 3 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		M20. Check by M20 B-12	Tapping n/c of 12.0.8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 n/c	Tapping Depth 16.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 4/7/25

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	5.5 n/c	2.27		Inner					
3	External Relief Depth		17 n/c		12 n/c					
4	Inspection Done Before Hardening By (Name)									Raw!
5	Material Sent For Hardening By (Name)									Lark furnace
6	Material Sent For Hardening On Date			4	7	25				

Inspected By (Sign) & Date

Raw: 4/7/25

Reviewed by (Engineer-CNC)

Manager-QA