



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.		15361	33/40/199
2	Machined By		V. T. L. H/c Shop	Drilling last 331
3	Pallet Die No.		13769(3.0) H/c	
4	Die Category	Drg. No.	5910	
5	Out Side Diameter	Drg. No.	50mm, Step 0.49mm	Step length 17.5
6	Inside Diameter	Drg. No.	42.14mm	
7	Width of Pellet Die	Drg. No.	18.2mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		45.4mm	
13	Tapping Hole Diameter		H2, Check by H2 R.12	Tapping H/c of holes 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sasi 2/7/25

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 G. Rep. 30
2	External Relief Dia	3.5mm	Outside (2-2)		Inner				
3	External Relief Depth		13mm		7mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date			2	7	25			

Inspected By (Sign) & Date

Sasi 2/8/25

Reviewed by (Engineer-CNC)

Manager-QA