



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10225

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.			
2	Machined By		15253	36/36
3	Pallet Die No.		W-7.6 n/c Shop	Qty 1000
4	Die Category	Drg. No.	13767(1.8)mm	Rev 2.0
5	Out Side Diameter	Drg. No.	32.0	
6	Inside Diameter	Drg. No.	49.8 mm, Step 02, 49.1 mm	Step length 17.5
7	Width of Pellet Die	Drg. No.	420.14 mm	
8	Grooves as per Drawing	Drg. No.	18.2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 mm / 12x8x3 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		45.4 mm	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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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

Count as Go
Rev: 6.2

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia						
3	External Relief Depth						
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

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Reviewed by (Engineer-CNC)

Manager-QA