



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)

10223

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15410	24/47
2	Machined By		V. T. L. n/c Shop	Dry Run Life 543
3	Pallet Die No.		12903(3.0) n/c	Rev. no
4	Die Category	Drg. No.	2x transverse	
5	Out Side Diameter	Drg. No.	614 n/c Step 00. 611.9 n/c	Step length 19.5
6	Inside Diameter	Drg. No.	520.14 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 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		565 n/c	
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: 20.4 n/c	Tapping Depth: 18.5
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

Counter. Goj

1	Counter Sinking Depth & Finish	ok						Rev: 38
2	External Relief Dia	3.5 n/c	80 Side (23-37)		Inner			
3	External Relief Depth		26 n/c		23 n/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		3	7	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA