



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.		15206	45/45
2	Machined By		V.T.L. m/c Shop	Drg No. 150/1135
3	Pallet Die No.		15824(6.0) m/c	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	40.5 m/c, 3 step 0.2, 390.5 m/c 3 step 0.2	95
6	Inside Diameter	Drg. No.	315.14 m/c	
7	Width of Pellet Die	Drg. No.	118 m/c	
8	Grooves as per Drawing	Drg. No.	9.5 x 7 x 3 m/c / 9.5 x 7 x 2 m/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		m/c Shop	
12	Tapping PCD		356 m/c	
13	Tapping Hole Diameter		0.315" 2 Check by 0.315" Dial	Tapping 4-7 of Holes 2-8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.6 m/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi: 5/7/25

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

Counters 00
Rev. 10

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5 m/c	Outside 0.2-2.5	Inner			
3	External Relief Depth		5 m/c	Mill			
4	Inspection Done Before Hardening By (Name)		Ravi:				
5	Material Sent For Hardening By (Name)		R.R.				
6	Material Sent For Hardening On Date		5	7	25		

Inspected By (Sign) & Date

Ravi: 5/7/25

F. Reviewed by (Engineer-CNC)

Manager-QA