



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.			
2	Machined By		15418	50/50
3	Pallet Die No.		V. T. L. H/C Shop	Dry Holes 12.0 403
4	Die Category	Drg. No.	15603(4.0) H/C	Reamed
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	519.9 H/C	Step 02 x 491.2 H/C
7	Width of Pellet Die	Drg. No.	420.14 H/C	Step length 17.5
8	Grooves as per Drawing	Drg. No.	158 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 H/C 12 x 8 x 3 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/C Shop	
13	Tapping Hole Diameter		454 H/C	
14	Tapping On Second Side	Half pitch of 1st side	0.916" 2 Chacks by 0.916" Bolt	Tapping of holes of both side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 18.4 H/C	Tapping Depth 16.6
17	Visual Inspection Before Gun Drilling		Yes	
			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

1	Counter Sinking Depth & Finish	OK							Rev: 20
2	External Relief Dia	4.5 H/C	Outside 22.25		Inner				
3	External Relief Depth		5 H/C		Mill				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		14	7	25				

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA