



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)

10192

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15412	42/42
2	Machined By		V. T. L. H/c Shop	Dr. H. 120.803
3	Pallet Die No.		15289 (4.0) H/c	Rev. 2.00
4	Die Category	Drg. No.	2.5 side	
5	Out Side Diameter	Drg. No.	604 H/c	Step 0.02 619 H/c
6	Inside Diameter	Drg. No.	52.14 H/c	Tap hole 10
7	Width of Pellet Die	Drg. No.	222 H/c	Step length 18.5
8	Grooves as per Drawing	Drg. No.	14x8x5 H/c / 14x8x5 H/c	Under cut 7.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		565 H/c	of holes 12
13	Tapping Hole Diameter		H2.2 Check by H2.2 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 20.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/7/25

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

Counter 60

1	Counter Sinking Depth & Finish	OK						Row 2 B1
2	External Relief Dia	4.5 H/c	Outside (2-3)		Inner			
3	External Relief Depth		5 H/c		Nil			
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

Ravi 21/7/25

Reviewed by (Engineer-CNC)

Manager-QA