



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)

10293

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15351	28/40
2	Machined By		V. T. L. H/c Shop	
3	Pallet Die No.		15172 (2.5) H/c	1 Dy 21-1.2.091
4	Die Category	Drg. No.	Senior	Renzo
5	Out Side Diameter	Drg. No.	500 H/c, 3rd 00 = 499 H/c	Tappet 12"
6	Inside Diameter	Drg. No.	420.14 H/c	Stch length 14 H/c
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12-8 x 3 H/c / 12-8 x 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		031/4" = Check by 031/4" Bolt	Tapping H. of holes 8
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth = 18.4 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 17/7/25

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 - 3 Hole. Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 280

1	Counter Sinking Depth & Finish	ok						Raw: 28
2	External Relief Dia	3.0 H/c	2.2 H/c		Inner			
3	External Relief Depth		18 H/c		12 H/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		17	7	25			

Inspected By (Sign) & Date

Raw: 17/7/25

17/7/25

Reviewed by (Engineer-CNC)

Manager-QA