



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.		15374	31/50
2	Machined By		V. T. L. H/c Shop	Drill No. 12.0.450
3	Pallet Die No.		15473 (2.8) H/c	Rev. 02
4	Die Category	Drg. No.	J&W	
5	Out Side Diameter	Drg. No.	730 H/c, Step 02, 744 H/c	Tapper 12°
6	Inside Diameter	Drg. No.	630.14 H/c	Step length 28.3
7	Width of Pellet Die	Drg. No.	290.6 H/c	Undercut 6.9 H/c
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 H/c / 15.3 x 8 x 5 H/c	Face side 4.6
9	Fitting Sizes on CNC Plate	Drg. No.	OK	0.8 H/c Dot
10	Drilling Area Surface Smoothness		OK	Back Side
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		685 H/c	of Hole 12
13	Tapping Hole Diameter		H20, Check by H20 Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 19/7/25

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 6
Top 53

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.3 H/c	23-35	Inner			
3	External Relief Depth	25 H/c		19 H/c			
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		19	7	25		

Inspected By (Sign) & Date

Ravi 19/7/25

Reviewed by (Engineer-CNC)

Manager-QA