



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.		14805 ✓	30/30
2	Machined By		V.T.L. n/c Shop	Dr 4.12.0.1309
3	Pallet Die No.		15349(1.2) n/c	Rev = 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	590 n/c	Step 00. 682 n/c
6	Inside Diameter	Drg. No.	530.14 n/c	Step length 27.5 n/c
7	Width of Pellet Die	Drg. No.	278 n/c	
8	Grooves as per Drawing	Drg. No.	43 x 8 x 8 n/c / 27 x 8 x 8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		594 n/c	[Tapping Holes of 4-12.8]
13	Tapping Hole Diameter		H16. Check by H16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	one Side Tapping and 1st Side One	31-t
15	Tapping Hole Depth		Drill Depth 25.4 n/c	Tapping Depth 23.3
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/7/25

131-t

1	As per programme no.			29.1 n/c width
2	Gun Drilling Work Completed On			18 n/c Depth
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No - 12 hole closed	

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

Counter 45

1	Counter Sinking Depth & Finish	OK							Rev 163
2	External Relief Dia								
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

Ravi 29/7/25

Reviewed by (Engineer-CNC)

Manager-QA