



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)

10382

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15542	37/47
2	Machined By		V. T. L. H/c Shop	Drill. 12.0. 87.5
3	Pallet Die No.		15298(3.0) H/c	Rev. 100
4	Die Category	Drg. No.	Extrawide	②
5	Out Side Diameter	Drg. No.	614 H/c	Step 00. 623 644 Tapper 112
6	Inside Diameter	Drg. No.	520.14 H/c	Step 14. 184
7	Width of Pellet Die	Drg. No.	222 H/c	Lead cut. 4.3
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	13x8x5 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		565 H/c	
13	Tapping Hole Diameter		H2. Check by H20 Bolt	
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

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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)		N/A

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

Counter: 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 H/c	Outside (3-3)		Inner				
3	External Relief Depth		16 H/c		10 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		29	7	25				

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA