



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)

10380

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15507	58/58
2	Machined By		V.T.L. H/c Shop	Dy H. 12.0.1318
3	Pallet Die No.		15906 (3.8) H/c	Rev. 00
4	Die Category	Drg. No.	End semi die	
5	Out Side Diameter	Drg. No.	636 H/c	Step 00, 612 H/c, Step length 19.5
6	Inside Diameter	Drg. No.	520.14 H/c (Bore Tapper, 0.6 H/c)	
7	Width of Pellet Die	Drg. No.	254 H/c	
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		H20, 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)		No	

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

Completed By

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.3 H/c	Outside (3.3)		Inner				
3	External Relief Depth		4 H/c		Will				
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