



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.			
2	Machined By		15800	45/55
3	Pallet Die No.		V.T.L. n/c Shop	Drg No. 18.0-407
4	Die Category	Drg. No.	15344(8.0) n/c	Rev. 00
5	Out Side Diameter	Drg. No.	M. Tumbo	
6	Inside Diameter	Drg. No.	709.9 n/c, Step 0.0, 892.9 n/c	
7	Width of Pellet Die	Drg. No.	600.14 n/c	Tappet = 12
8	Grooves as per Drawing	Drg. No.	222 n/c	Step length 20 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x7 n/c / 12x8x7 n/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		n/c Shop	Tapping n/c
13	Tapping Hole Diameter		640 n/c	of holes 12
14	Tapping On Second Side	Half pitch of 1st side	H20. Check by H20 Bol	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 n/c	Tapping Depth 18
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

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

1	Counter Sinking Depth & Finish	OK							Counter 60
2	External Relief Dia	8.5 n/c	Outside 23-25		Inner				Rev 18
3	External Relief Depth		18 n/c		10 n/c				
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

8/8/25

8/8/25

Reviewed by (Engineer-CNC)

Manager-QA