



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.		15595	40/501
2	Machined By		V.T.L n/c Shop	Drill 23.7045
3	Pallet Die No.		15478(4.0) n/c	Rev. 02
4	Die Category	Drg. No.	7820	
5	Out Side Diameter	Drg. No.	73044, Step 002, 74444, Tapped 1-	
6	Inside Diameter	Drg. No.	6301444	Step length 23.3
7	Width of Pellet Die	Drg. No.	290.644	Outer cut 27 n/c
8	Grooves as per Drawing	Drg. No.	15.3x8x544 / 15.3x8x544	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Drill Side Step
10	Drilling Area Surface Smoothness		ok	0.8 mm Deep
11	Tapping Operator		n/c Shop	Back Side
12	Tapping PCD		38544	Tapping 44
13	Tapping Hole Diameter		M20 Check by M20 Bolt	of Hole 16
14	Tapping On Second Side	Half pitch of 1st side	ok	Back Side
15	Tapping Hole Depth		Drill Depth 20.644	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/8/25

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

1	Counter Sinking Depth & Finish	ok								Count 21/8/25
2	External Relief Dia	4.544	Outside (2-3)		Inner					Rev. 42
3	External Relief Depth		1444		1044					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		01	08	25					

Inspected By (Sign) & Date

Ravi 21/8/25

Reviewed by (Engineer-CNC)

Manager-QA