



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.		15780	25/50
2	Machined By		V.T.L. n/c Shop	Drg. H. 13.2.4.0
3	Pallet Die No.		15426(4.0) n/c	Rev. 00
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	620mm Step on 622.4mm	Tapper 02
6	Inside Diameter	Drg. No.	52.14mm	Step length 18mm
7	Width of Pellet Die	Drg. No.	222mm	Under cut 1.2mm
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565mm	Tapping Ho of holes 12
13	Tapping Hole Diameter		H20 Crack by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.5mm Tapping Depth 18.4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/8/25

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 - 1 Hole Closed

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

1	Counter Sinking Depth & Finish	ok						Counter Bo
2	External Relief Dia	u.5mm	Outside 23-35	Inner				Rev. 31
3	External Relief Depth		19mm	15mm				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		22	8	25			

Inspected By (Sign) & Date

Ravi 22/8/25

Reviewed by (Engineer-CNC)

Manager-QA