



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		15751/	29/50/
3	Pallet Die No.		N.T.L. n/c Shop	Dr. H. L. R. 998
4	Die Category	Drg. No.	15422(4.0)H	Reason
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	619.9H, Step 00.	Tapper. 12.5
7	Width of Pellet Die	Drg. No.	520.14H	Step length. 18.5
8	Grooves as per Drawing	Drg. No.	222H	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5H / 13x8x5H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565H	
13	Tapping Hole Diameter		H20: Crack by H20 Bolt	[Tapping H. of Holes. 12]
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth. 20.5H	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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. G.
2	External Relief Dia	4.5H	Outside (3-3)		Inner				Row 2 B1
3	External Relief Depth		15H		11H				
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

22/8/25

Reviewed by (Engineer-CNC)

Manager-QA