



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.		14407	40/50
2	Machined By		V.T.L. H/c Shop	By H. L. S. 998
3	Pallet Die No.		15418(4.5) H	Review
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/c Step 001	Tapper 12.5
6	Inside Diameter	Drg. No.	520.14 H	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H / 13x8x5 H	
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	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.5 H	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

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	4.8 H	Outside 3.3		Inner			Review
3	External Relief Depth		15 H		10 H			
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