



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		15836	35/42
3	Pallet Die No.		V.T.L. n/c Shop	Drill H. 18.0.783
4	Die Category	Drg. No.	15659(3.5) H	Rev. 00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	499.9 mm, Step OD - 491.8 mm	Step length 7.5
7	Width of Pellet Die	Drg. No.	420.14 mm	
8	Grooves as per Drawing	Drg. No.	158 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 mm / 12x8x3 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		454 mm	
14	Tapping On Second Side	Half pitch of 1st side	H20: Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 18.4 mm	Tapping Depth 16.4
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 29/8/25

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 ex. 60
2	External Relief Dia	4.0 mm	Outside (2-2)		Inner			Rev - 22
3	External Relief Depth		8 mm		5 mm			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		29	8	25			

Inspected By (Sign) & Date

Ravi 29/8/25

Reviewed by (Engineer-CNC)

Manager-QA