



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15876	5.15
2	Machined By		V.T.L. H/C Shop	Drg. No. 18.2450
3	Pallet Die No.		15768(6.0) H/C	Rev. 02
4	Die Category	Drg. No.	740	
5	Out Side Diameter	Drg. No.	730 H/C, Step OP: 744 H/C	Tappet 10
6	Inside Diameter	Drg. No.	630.14 H/C	Step length 23.3
7	Width of Pellet Die	Drg. No.	290.6 H/C	Undercut 7 H/C
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 H/C / 15.3 x 8 x 5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Once Side Step
10	Drilling Area Surface Smoothness		OK	0.8 H/C Deck
11	Tapping Operator		H/C Shop	Both Side
12	Tapping PCD		685 H/C	Tapping Ho
13	Tapping Hole Diameter		H20: Check by H20 Ball	of holes 16
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 20.5 H/C	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

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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 en. Rev
2	External Relief Dia	6.5 H/C	Outside (23.3)		Inner			Rev: 31
3	External Relief Depth		6 H/C		Nil			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		2	9	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA