



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10582

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.		14285/	32/55/
2	Machined By		V.T.L. H/c Shop	Drg. No. 12.0.1220
3	Pallet Die No.		14833(4.0)H/c	Revised
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	630 H/c Step 02.62 H/c Step length 16.0	
6	Inside Diameter	Drg. No.	520.14 H/c	
7	Width of Pellet Die	Drg. No.	172 H/c	
8	Grooves as per Drawing	Drg. No.	11x5x3 H/c / 11x5x3 H/c	
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/c	
13	Tapping Hole Diameter		720, Check by H20 Ball	Tapping of Holes = 2 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 H/c	Tapping Depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Posi 31/9/25

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

Counter 26

1	Counter Sinking Depth & Finish	ok						Rev. 23
2	External Relief Dia	4.5 H/c	Outside (3-3)		Inner			
3	External Relief Depth		27 H/c		23 H/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		3	9	25			

Inspected By (Sign) & Date

Posi 31/9/25

Reviewed by (Engineer-CNC)

Manager-QA