



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)

10588

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15825	24/50
3	Pallet Die No.		V.T.L. H/c Shop	Qty 12.971
4	Die Category	Drg. No.	15430(3.0) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	Ext. outside	
6	Inside Diameter	Drg. No.	620 H/c	Step 02. 620 H/c
7	Width of Pellet Die	Drg. No.	520.14 H/c	Tapping 12
8	Grooves as per Drawing	Drg. No.	222 H/c	Step length - 12
9	Fitting Sizes on CNC Plate	Drg. No.	9x10x 4 H/c / 9x10x 4 H/c	Under cut - 1 H/c
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20	Check by H20 Ball
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 28.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Inspected: 4/9/25

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

1	Counter Sinking Depth & Finish	ok								Counter. G.
2	External Relief Dia	3.5 H/c	outside (2-3)		inner					Rev. 32
3	External Relief Depth		29 H/c		26 H/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		04	9	25					

Inspected By (Sign) & Date

Inspected: 4/9/25

Reviewed by (Engineer-CNC)

Manager-QA