



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)

10613

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15869 ✓	34/50 ✓
2	Machined By		V. T. L. H/O Shop	8355
3	Pallet Die No.		15012 (2.8) ✓	1 Dry Holes last 33.0
4	Die Category	Drg. No.	2 x 2 x 2 side	
5	Out Side Diameter	Drg. No.	619.9 mm ✓ Step 00.611.9 mm ✓	Step 00.611.9 mm ✓
6	Inside Diameter	Drg. No.	520.14 mm ✓	
7	Width of Pellet Die	Drg. No.	222 mm ✓	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 mm ✓ 13 x 8 x 5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		565 mm ✓	[Tapping Holes 12
13	Tapping Hole Diameter		H202 Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm ✓	Tapping Depth 20.4 mm ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Soni 8/9/25

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 - 1 Hole Colused

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counters 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.2 mm ✓	Outside 3.2 - 3.2		Inner				
3	External Relief Depth		22 mm ✓		18 mm ✓				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date			8	9	25			

Inspected By (Sign) & Date

Soni 8/9/25

Reviewed by (Engineer-CNC)

Manager-QA