



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)

10612

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15859	17/66
3	Pallet Die No.		V. T. L. H/c Shop	Dr. No. 12.0.0.9
4	Die Category	Drg. No.	15863(6.0) H/c	Rev. 03
5	Out Side Diameter	Drg. No.	H. T. J. H/c	
6	Inside Diameter	Drg. No.	680.7 H/c	Step 00, 693 H/c
7	Width of Pellet Die	Drg. No.	546.14 H/c	Step length = 31 H/c
8	Grooves as per Drawing	Drg. No.	195 H/c	Under cut = 2.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.2 H/c	(4 x 9) H/c
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		H/c Shop	2 H/c Deep Bottom
12	Tapping PCD		619 H/c	Side
13	Tapping Hole Diameter		H/c	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	H/c	of H/c. 2
15	Tapping Hole Depth		Drill Depth 33.4 H/c	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 31.0
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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

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

1	Counter Sinking Depth & Finish	ok								Counter 30
2	External Relief Dia	7.5 H/c								Rev. 12
3	External Relief Depth									
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date

Ravi 8/9/25

Reviewed by (Engineer-CNC)

Manager-QA