



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)

10692

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16048	36/50
2	Machined By		V.T.L H/c Shop	Dray No 2-18.0.528
3	Pallet Die No.		15702 (4.0) H	Rev. 01
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	619.9 H	Step OD = 615.4 H
6	Inside Diameter	Drg. No.	520.14 H	Tapper = 4°
7	Width of Pellet Die	Drg. No.	222 H	Step length = 20 H
8	Grooves as per Drawing	Drg. No.	13x8 = 5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8 = 5 H	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H	
13	Tapping Hole Diameter		H20 = Check by M20 Roll	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 H	Tapping depth = 18.4 H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 20/9/25

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 = 60
2	External Relief Dia	4.3 H	Outside 23-33							Row = 31
3	External Relief Depth		18 H							
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										

Satya 20/9/25

Reviewed by (Engineer-CNC)

Ravi 20/9/25

Manager-QA