

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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		18050	45/55
2	Machined By		V.T.L. M/c Shop	Dry No. 120.4
3	Pallet Die No.		15283(8.0) H	Revol.
4	Die Category	Drg. No.	33370	
5	Out Side Diameter	Drg. No.	622.9 H	Step 2D - 622.9 H
6	Inside Diameter	Drg. No.	520.14 H	Step length 18 H
7	Width of Pellet Die	Drg. No.	186 H	
8	Grooves as per Drawing	Drg. No.	13x8x3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		565 H	of Hole
13	Tapping Hole Diameter		H20	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 H	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 22/9/25

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	8.5 H	8.5 H	Inner				Row = 14
3	External Relief Depth		18 H	10 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

Ravi 22/9/25

Reviewed by (Engineer-CNC)

Manager-QA