



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.			
2	Machined By		16101	45/50
3	Pallet Die No.		V.T.L M/c Shop	Dry No 2 B.N. 403
4	Die Category	Drg. No.	16022(40) M/c	Rev 200
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	5.20 M/c	Step OD = 4.91 M/c
7	Width of Pellet Die	Drg. No.	4.20 M/c	Step length = 2.5
8	Grooves as per Drawing	Drg. No.	1.58 M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	1.2 x 8 x 3 M/c	1.2 x 8 x 3 M/c
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	Tapping No
13	Tapping Hole Diameter		4.54 M/c	of Holes 28
14	Tapping On Second Side	Half pitch of 1st side	0.3/4" Check by 0.3/4" B.N.	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 18.8 M/c	Tapping depth = 18.5
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

Ravi 03/10/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
4	Defective Holes (If Any)		OK No

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

1	Counter Sinking Depth & Finish	OK						Counter 28
2	External Relief Dia	4.3 M/c	8.2 M/c					Row 2 25
3	External Relief Depth		1.3 M/c					
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 03/10/25

Manager-QA

Reviewed by (Engineer-CNC)