



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.		16091	40/40
2	Machined By		V.T.L. H/c Shop	Drg No. 12.0.335
3	Pallet Die No.		15667(4.0)H	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9H, Step 00, 490.9H	
6	Inside Diameter	Drg. No.	420.14H	Step length = 17.5
7	Width of Pellet Die	Drg. No.	158H	
8	Grooves as per Drawing	Drg. No.	12x8x3H / 12x8x3H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454H	Tapping H/c of Holes = 8
13	Tapping Hole Diameter		03/4" = Check by 03/4" Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.4H, Tapping Depth = 16.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rao: 10/10/25	
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 on Sp. Row 20
2	External Relief Dia	4.5H	Outside 2.25	Inner
3	External Relief Depth		4H	Mill
4	Inspection Done Before Hardening By (Name)		Rao	
5	Material Sent For Hardening By (Name)		Lark Lawrence	
6	Material Sent For Hardening On Date		10 10 25	
Inspected By (Sign) & Date			Rao: 10/10/25	

Reviewed by (Engineer-CNC)

Manager-QA