



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.		16177	38/50
2	Machined By		V. T. L. H/c Shop	Dr. H/c 18.0.05
3	Pallet Die No.		14952(8.0) H/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9 H/c Step 00. 498.8 H/c	Tap hole 12"
6	Inside Diameter	Drg. No.	420.14 H/c	Step length 17 H/c
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x 8x 3 H/c / 12x 8x 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tap hole 12"
12	Tapping PCD		454 H/c	of hole 8"
13	Tapping Hole Diameter		0.314" Check by scriber Bolt	Body side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.5 H/c	Tapping Depth 0.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 13/10/25

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. Go
2	External Relief Dia	8.5 H/c	20 Side (2-2)		Inner			Raw: 12
3	External Relief Depth		20 H/c		12 H/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

Raw: 13/10/25

Reviewed by (Engineer-CNC)

Manager-QA