



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

10985
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.		16365	37/50
2	Machined By		V. T. L. n/c Shop	Drilling 1.8 = 9.8
3	Pallet Die No.		15844 (3.5) n/c	Rev 2.00
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	62.77	Step 00. Tapper 12°
6	Inside Diameter	Drg. No.	52.14 n/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	22.2 n/c	
8	Grooves as per Drawing	Drg. No.	13.8 x 5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		56.5 n/c	Tapping No. of Holes - 12
13	Tapping Hole Diameter		M20. Check by M20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/1/25

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

Counter - 60
Rep - 35

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.0 n/c	outside 23.35		Inner		
3	External Relief Depth		17 n/c		13 n/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 11/1/25

Reviewed by (Engineer-CNC)

Manager-QA