



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.		14461	31/50
2	Machined By		V.T.L. H/c Shop	Drg. No. 13.0.2.450
3	Pallet Die No.		13499 (2.2) H/c	Rev. 1.00
4	Die Category	Drg. No.	7820	
5	Out Side Diameter	Drg. No.	730 H/c, Step 00, 743.5 H/c	Tapping 13
6	Inside Diameter	Drg. No.	630.12 H/c	Step length 23
7	Width of Pellet Die	Drg. No.	290 H/c	Under cut 6.75
8	Grooves as per Drawing	Drg. No.	15x8x5 H/c / 15x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		685 H/c	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	Tapping dia of holes 16
14	Tapping On Second Side	Half pitch of 1st side	OK	Back Side
15	Tapping Hole Depth		Drill Depth 20.2 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/3/25

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

Counters 60

1	Counter Sinking Depth & Finish	OK								Rev. 1.53
2	External Relief Dia	3.3 H/c	Outside 23.35		Inner					
3	External Relief Depth		25 H/c		19 H/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		17	3	25					

Inspected By (Sign) & Date

Ravi 17/3/25

Reviewed by (Engineer-CNC)

Manager-QA