



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.		15190	42/45
2	Machined By		V.T.L. H/c Shop	Dy H. 18.0. 135
3	Pallet Die No.		14514 (6.0) H	Rev. on
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510 H/c Shop 002 498 H	Step by 3.5
6	Inside Diameter	Drg. No.	42.14 H	
7	Width of Pellet Die	Drg. No.	152 H	
8	Grooves as per Drawing	Drg. No.	11x5x3 H / 11x5x3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		456 H	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Ball	Tapping H of Holes & Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 16.5 H	Tapping Depth 14.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rao: 14/6/25

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

1	Counter Sinking Depth & Finish	ok								Rao: 15
2	External Relief Dia	6.5 H	Outside (2-2)		Inner					
3	External Relief Depth		9 H		3 H					
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

Rao: 14/6/25

Reviewed by (Engineer-CNC)

Manager-QA