



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.		15787	20/40
2	Machined By		V. T. L. H/c Shop	Dr. H. 12.0.90
3	Pallet Die No.		15278(3.0) H/c	Rev. 00
4	Die Category	Drg. No.	OS Senior	
5	Out Side Diameter	Drg. No.	499.8 H/c Step 00	490.8 H/c Step 17
6	Inside Diameter	Drg. No.	420.14 H/c	
7	Width of Pellet Die	Drg. No.	157.8 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 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		454 H/c	
13	Tapping Hole Diameter		031/4" - Check by 031/4" Ball	Tapping H/c of Holes - 8 Side Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.6 H/c	Tapping Depth 18.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rev: 26/8/25

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 = 6
2	External Relief Dia	3.5 H/c	2-2		Inner			Rev. 24
3	External Relief Depth		13 H/c		10 H/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		26	8	25			

Inspected By (Sign) & Date

Rev: 26/8/25

Reviewed by (Engineer-CNC)

Manager-QA