



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.		13142 to 13275	44/50
2	Machined By		V. T. L. N/A Shop	Digital L&C 9980
3	Pallet Die No.		13113(4.0) N/A	Row 1
4	Die Category	Drg. No.	Get outside	
5	Out Side Diameter	Drg. No.	62.4mm	Step 12°
6	Inside Diameter	Drg. No.	52.12mm	Step length 18.5
7	Width of Pellet Die	Drg. No.	22.2mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping side of Holes: 12° Both Side
12	Tapping PCD		56.5mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/10/24

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 60° Row 2 31
2	External Relief Dia	4.3mm	Outside 3-3)		Inner				
3	External Relief Depth		14mm		6mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Romance
6	Material Sent For Hardening On Date		21	10	24				

Inspected By (Sign) & Date

Ravi 21/10/24

Satyam 21/10/24

Reviewed by (Engineer-CNC)

Manager-QA