



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.		13066	40/40
2	Machined By		V. TIL H/c Shop	Drg. No. L2C2719G
3	Pallet Die No.		12739(3.0)mm	Rev. 01 27/28
4	Die Category	Drg. No.	5920	
5	Out Side Diameter	Drg. No.	500mm / Step OD 492mm	Step length 17mm
6	Inside Diameter	Drg. No.	420.12mm	
7	Width of Pellet Die	Drg. No.	173mm	
8	Grooves as per Drawing	Drg. No.	10x8x3mm / 10x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		455mm	
13	Tapping Hole Diameter		Ø3/4" - Check by Ø3/4" Bolt	Tapping No. of holes 8
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 19.3mm Tapping Depth 17.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/10/24

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° Low = 29
2	External Relief Dia	3.5mm	outside (2-2)		Inner		
3	External Relief Depth		6mm		Mill		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Porroce		
6	Material Sent For Hardening On Date		23	10	24		

Inspected By (Sign) & Date

Ravi 23/10/24

Satyam 23/10/24

Reviewed by (Engineer-CNC)

Manager-QA