



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.		13672	31/50
2	Machined By		V. TIL H/c Shop	
3	Pallet Die No.		13052(2.8)H	Dy No. 1-20-276
4	Die Category	Drg. No.	58870	Rev 01
5	Out Side Diameter	Drg. No.	62.3 H	Step OD = 62.4 H
6	Inside Diameter	Drg. No.	52.12 H	
7	Width of Pellet Die	Drg. No.	186 H	Tabber, 12
8	Grooves as per Drawing	Drg. No.	13x8x3 H	Step length 2 H
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 H	Under cut = 12 H
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H	Tapping No of holes = 12 Both Side
13	Tapping Hole Diameter		H2, Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth, 20.3 H	Tapping Depth, 18.6 H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/12/24

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						Coorden, 6°
2	External Relief Dia	3.3 H	outside (3-3)		Inner			Row 231
3	External Relief Depth		25 H		19 H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		24	12	24			
Inspected By (Sign) & Date		Ravi 24/12/24						

Reviewed by (Engineer-CNC)

Manager-QA