



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9033

Form No. CNC/QA/FM/02

Rev. No. 01

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13975	40/50
2	Machined By		V. T. L n/c Shop	Dry run L/C 993
3	Pallet Die No.		13741 (4.0) n/c	Rev 200
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	619.9 n/c	Tapper - 12
6	Inside Diameter	Drg. No.	520.12 n/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		565 n/c	
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 20.2 n/c	Tapping Dept. 18.5 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/1/25

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								
2	External Relief Dia	4.5 n/c	Outside 3.3		Inner					
3	External Relief Depth		14 n/c		10 n/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		21		25					

Inspected By (Sign) & Date

Ravi 21/1/25

Reviewed by (Engineer-CNC)

Manager-QA