



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.		13884	30/40
2	Machined By		V. T. L N/A Shop	Dy No. L.S.D. 878
3	Pallet Die No.		13861 (3.5)	Rev. 20
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390mm Step OD. 385mm	Step length 11.5
6	Inside Diameter	Drg. No.	310.12	
7	Width of Pellet Die	Drg. No.	144mm	
8	Grooves as per Drawing	Drg. No.	10x7x4mm / 10x7x4mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	Tapping No. of Holes & Body Side
12	Tapping PCD		350mm	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2mm Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24/1/25

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							Counter 20
2	External Relief Dia	4.0mm	outside (2.2)		Inner				
3	External Relief Depth		14mm		10mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		24		25				

Inspected By (Sign) & Date

Ravi 24/1/25

Reviewed by (Engineer-CNC)

Manager-QA