



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.		14093 ✓	36/45 ✓
2	Machined By		V.T.L. n/c Shop	By H. S. 1.3.02 302
3	Pallet Die No.		14381 (6.0) n/c	Rev 1.0
4	Die Category	Drg. No.	5910	
5	Out Side Diameter	Drg. No.	509.8 n/c Ⓢ Step OD. 490.8 n/c	Step length 6.5
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	173 n/c	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 n/c / 10x8.5x5 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 L. 1.0 - B. 1.0 Side
12	Tapping PCD		455 n/c	
13	Tapping Hole Diameter		Ⓢ 3/4" - Check by Ⓢ 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.3 n/c	Tapping Depth: 18.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Soni 14/2/25	
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: 60 Rev: 17
2	External Relief Dia	6.5 n/c	outside 22-23	Inner
3	External Relief Depth		15 n/c	9 n/c
4	Inspection Done Before Hardening By (Name)		Soni	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		14	2 25
Inspected By (Sign) & Date			Soni 14/2/25	

Soni 14/2/25

Reviewed by (Engineer-CNC)

Manager-QA