



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.		14038	4046
2	Machined By		V.T.L. n/c Shop	Drg No. 13.0975
3	Pallet Die No.		14081 (B.O) n/c	Rev: 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	409.8 mm	Step 00, 382.6 mm, Step length 10.5
6	Inside Diameter	Drg. No.	315.12 mm / 318.12 mm	
7	Width of Pellet Die	Drg. No.	108 mm	
8	Grooves as per Drawing	Drg. No.	4x5x3 mm / 4x5x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		350 mm	
13	Tapping Hole Diameter		0.12" = Check by 0.12" Tap	Tapping No of Holes = 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 12.8 mm Tapping Depth: 10.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/2/25

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 Sink
2	External Relief Dia	0.5 mm	Outside (2-2)	Inner					Rev: 11
3	External Relief Depth		10 mm	6 mm					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		17	2	25				

Inspected By (Sign) & Date

Ravi 17/2/25

Sats 17/2/25
Reviewed by (Engineer-CNC)

Manager-QA