



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.		14340	45/50
2	Machined By		V.T.L. n/c Shop	Dry Holes 12/09/80
3	Pallet Die No.		14172 (G.O) n/c	Rev. 00
4	Die Category	Drg. No.	Perf. inside	
5	Out Side Diameter	Drg. No.	619.9 mm Step 02 Tapper 12°	
6	Inside Diameter	Drg. No.	520.12 mm	Step length 12.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm 13x8x5 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		585 mm	
13	Tapping Hole Diameter		H20, Check by H20 Bolt	Tapping Holes 12
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 20.2 mm Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/3/25

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 Bore
2	External Relief Dia	6.5 mm	Outside 23-25		Inner			Rev 2 23
3	External Relief Depth		11 mm		5 mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Por neck
6	Material Sent For Hardening On Date		13	3	25			

Inspected By (Sign) & Date

Ravi 13/

Reviewed by (Engineer-CNC)

Manager-QA