



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.		14427	37/50
2	Machined By		V.T.L. H/C Shop	Drg No. 1.2.2.298
3	Pallet Die No.		14299 (3.5) H/C	Rev. 00
4	Die Category	Drg. No.	9x2 outside	
5	Out Side Diameter	Drg. No.	619.9 H/C	Step 002
6	Inside Diameter	Drg. No.	520.12 H/C	Tabber 12"
7	Width of Pellet Die	Drg. No.	222 H/C	Step length 18.5
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		H20 Check by H20 Bolt	[Tapping No. of holes 12]
14	Tapping On Second Side	Half pitch of 1st side	ok	[Both Side]
15	Tapping Hole Depth		Drill Depth 20.3 H/C	Tapping Depth 18.6"
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 60°
2	External Relief Dia	3.8 H/C	80% side (2-3)		Inner			Rev 35
3	External Relief Depth		17 H/C		13 H/C			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Forrere
6	Material Sent For Hardening On Date		13	2	25			

Inspected By (Sign) & Date

Ravi 13/3/25

Reviewed by (Engineer-CNC)

Manager-QA