



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.		14379 ✓	50/50
2	Machined By		V. T. L. n/c Shop	Dr. 150.1370
3	Pallet Die No.		14267 14267 (A) ✓	Recess
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm, Step 00, 491 mm	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm 12 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Tapping Holes of holes 8 Both Side]
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi: 17/3/25	
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		Count in 6°
2	External Relief Dia	8.3 mm	outside (2-2)	12/212
3	External Relief Depth		4 mm	Nil
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Perinack	
6	Material Sent For Hardening On Date		17 3 25	
Inspected By (Sign) & Date			Sasi: 17/3/25	

Reviewed by (Engineer-CNC)

Manager-QA