



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.		14440	44/55
2	Machined By		V.T.L. H/c Shop	Q. Dr. 18.02.13
3	Pallet Die No.		13592	Recess
4	Die Category	Drg. No.	Entrance	
5	Out Side Diameter	Drg. No.	629.8 mm Step on 623.9 mm Tapper 12"	
6	Inside Diameter	Drg. No.	520.12 mm	Step length 12 mm
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		H/c Shop	Tapping H/c
12	Tapping PCD		565 mm	of Holes 12
13	Tapping Hole Diameter		M20 Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 mm Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 18/3/25	
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 - 1 Hole Colused	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok	Q. counter - Ravi Row 31	
2	External Relief Dia	4.5 mm	Outside (3-3)	Inner
3	External Relief Depth		19 mm	11 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Forracc	
6	Material Sent For Hardening On Date		18	3 25
Inspected By (Sign) & Date			Ravi 18/3/25	

Reviewed By (Engineer-CNC)

Manager-QA