

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

9522

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14281	45/45
2	Machined By		V. T. L. H/c Shop	Dy No. 1.2.0.01135
3	Pallet Die No.		A31 14882 (6.0)	Recess
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	40.5 mm Step 00.390.5 mm Step length 9.5	
6	Inside Diameter	Drg. No.	315.12 mm	
7	Width of Pellet Die	Drg. No.	118 mm	
8	Grooves as per Drawing	Drg. No.	9.5 x 7 x 3 mm 9.5 x 7 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		356 mm	
13	Tapping Hole Diameter		0.31" 2 Check by 0.31" Bolt	Tapping H. of holes 8 Bolt Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 mm Tapping Depth 16.0	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 3/4/25

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	80 Side 82.25		Inner				Rough
3	External Relief Depth		5 mm		Mill				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

Ravi 3/4/25

Reviewed by (Engineer-CNC)

Manager-QA