

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)

9537

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14611 ✓	37/40
2	Machined By		V.T.L. N/C Shop	15002
3	Pallet Die No.		13995 (3.5) ✓	Rev. 1.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5mm ✓ Step 002 498.88 ✓ Tappet 12	
6	Inside Diameter	Drg. No.	420.12 mm (Per Tappet 03) Step length 218	
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	
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 18.2 mm ✓ Tapping Depth 13.2	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 5/4/25

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 60
2	External Relief Dia	4.0 mm	Outside 2.25		Inner					Row 22
3	External Relief Depth		7 mm		3 mm					
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 5/4/25

Reviewed by (Engineer-CNC)

Manager-QA