



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9665

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.		14662	31/40
2	Machined By		V.T.L. H/c Shop	Drilling (2.0.865)
3	Pallet Die No.		14950 (2.8) H/c	Recess
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390mm Step 02. 383mm	Step length 115mm
6	Inside Diameter	Drg. No.	310.12mm	
7	Width of Pellet Die	Drg. No.	135mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		350mm	Tapping H/c of holes 8
13	Tapping Hole Diameter		03/4" - Check by 03/4" Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 19/4/25	
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	3.3mm	Outside (2-2)	Row 21
3	External Relief Depth		15mm	Inner 9mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For race	
6	Material Sent For Hardening On Date		19 4 25	
Inspected By (Sign) & Date			Ravi 19/4/25	

Reviewed by (Engineer-CNC)

Manager-QA