



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.		14806	40/50
2	Machined By		V. T. L. n/c Shop	(1 Day H. 18.2.14.5
3	Pallet Die No.		15108 (R.5) H	Rev 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520mm Step 00. 499mm	Tabber 12°
6	Inside Diameter	Drg. No.	420.12mm	Step length 17mm
7	Width of Pellet Die	Drg. No.	158mm	
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		n/c Shop	
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		03/4" - Check by 03/4" Bolt	Tapping No. of H. 12. B Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/4/25

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 B
2	External Relief Dia	4.0mm	22.25		Inner			Rev. 22
3	External Relief Depth		17mm		10mm			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		23	4	25			

Inspected By (Sign) & Date

Ravi 23/4/25

Reviewed by (Engineer-CNC)

Manager-QA