



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)

9713

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14699	40/40
2	Machined By		V.T.L. N/C Shop	9199
3	Pallet Die No.		13526(3.5)	910
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 mm	Step length 14.5
6	Inside Diameter	Drg. No.	320.12 mm	
7	Width of Pellet Die	Drg. No.	142 mm	
8	Grooves as per Drawing	Drg. No.	15.5 x 8 x 2 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		355 mm	
13	Tapping Hole Diameter		M16	Tapping Hole of holes 8
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.6 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24/4/25

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 Bo
2	External Relief Dia	4.0 mm	Outside 2-2		Inner			2-18
3	External Relief Depth		4 mm		Mill			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Romach			
6	Material Sent For Hardening On Date		24	4	25			

Inspected By (Sign) & Date

Ravi 24/4/25

Reviewed by (Engineer-CNC)

Manager-QA