



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.		14755	35/40
2	Machined By		N.T.L. m/c Shop	Drg No. 130281
3	Pallet Die No.		13761 (3.2) m/c	Rev: 00
4	Die Category	Drg. No.	820	
5	Out Side Diameter	Drg. No.	500 mm, Step 00 - 490.7 mm	Step length 16.5
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	173 mm	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 5 mm / 12 x 10 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		m/c Shop	Tapping No. of Holes: 8
12	Tapping PCD		455 mm	Both Side
13	Tapping Hole Diameter		03/4" - Check by angle Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
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 30/4/25	
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	3.5 mm	Outside (2.2)	Rev - 26
3	External Relief Depth		7 mm	5 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Pernace	
6	Material Sent For Hardening On Date		30 4 25	
Inspected By (Sign) & Date			Ravi 30/4/25	

Reviewed by (Engineer-CNC)

Manager-QA