



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)

10/09

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15274 ✓	36/50
2	Machined By		V. T. L. n/c Shop	Drilling 1-2-2-125
3	Pallet Die No.		14407 (4.0) ✓	Revised
4	Die Category	Drg. No.	Mr. Jumbo	
5	Out Side Diameter	Drg. No.	700 mm Step 002 692.8 mm	Tapping 12
6	Inside Diameter	Drg. No.	600.14 mm	Step length 2.25
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12x8x7 mm / 12x8x7 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		640 mm	Tapping Holes 12
13	Tapping Hole Diameter		420 Check by 420 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/6/25

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 - 1 Hole Closed	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter : 30

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 mm	Outside (3-3)		Inner				
3	External Relief Depth		18 mm		14 mm				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Perior				
6	Material Sent For Hardening On Date		18	6	25				

Inspected By (Sign) & Date

Ravi 18/6/25

Reviewed by (Engineer-CNC)

Manager-QA