



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 (Pollet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15318 ✓	6.16.0 ✓
2	Machined By		N.T.L. n/c Shop	Day H. 1.8.2362
3	Pallet Die No.		14200 (8.0) n/c	Rev. 00
4	Die Category	Drg. No.	J&D	
5	Out Side Diameter	Drg. No.	750 n/c	Step on = 743.9 n/c
6	Inside Diameter	Drg. No.	630.14 n/c	Tap hole = 10"
7	Width of Pellet Die	Drg. No.	290.6 n/c	Step length 23.3"
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 n/c / 15.3 x 8 x 5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	0.8 n/c (Back Side)
11	Tapping Operator		N/c Shop	Tapping H. of H. 1.8.216
12	Tapping PCD		685 n/c	Both Side
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 20.4 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rev. 2/7/25

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 - 0.1
2	External Relief Dia	8.5 n/c	outside (3.3)		Inner			Rev. 25
3	External Relief Depth		5 n/c		Nil			
4	Inspection Done Before Hardening By (Name)							Rev.
5	Material Sent For Hardening By (Name)							1.0 n/c R. 25
6	Material Sent For Hardening On Date							2. 25

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA