

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.		15874	45/45
2	Machined By		V.T.L M/c Shop	Day No. 1-2-02/152
3	Pallet Die No.		15878 (2.8) mm	Rev 000
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	509.9 mm	Step 0D. 490.9 mm
6	Inside Diameter	Drg. No.	420.14 mm	Step length. 14.5
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm / 12 x 8 x 3 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		454 mm	Both side
13	Tapping Hole Diameter		03/4" = Check by 03/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.4 mm	Tapping Depth 16.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		No	
Inspected By (Sign) & Date			Ravi 10/9/25	Approver
1	As per programme no.			Byg.
2	Gun Drilling Work Completed On			Sachin Sir
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	3.2 mm	2.25	Row. 28
3	External Relief Depth		6 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		10 9 25	
Inspected By (Sign) & Date			Ravi 10/9/25	

Reviewed by (Engineer-CNC)

Manager-QA