



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.		15873	58/60
2	Machined By		V.T.I. M/c Shop	Dry No. 1ec-15000
3	Pallet Die No.		16195 (5.0) mm	(Rev. 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	539.9 mm	Step OD, 490.9 mm
6	Inside Diameter	Drg. No.	420.14 mm	Step length 17.5
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm	12x8x3 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		453.9 mm	of holes-8
13	Tapping Hole Diameter		M-20 check by M-20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.4 mm	Tapping Depth = 16.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 15/9/25

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

Counter-60

1	Counter Sinking Depth & Finish	OK	outside	Inner			Row-17
2	External Relief Dia	5.5 mm	(2-2) 6mm	(2 mm)			
3	External Relief Depth						
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date			15	9	25	

Inspected By (Sign) & Date

Ravi 15-9-25

Reviewed by (Engineer-CNC)

Manager-QA