



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10663

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.		15644	50/55
2	Machined By		V. T. L. N/C Shop	Dr H. 13.0.215
3	Pallet Die No.		16322 (3.5) mm	Rev. 00
4	Die Category	Drg. No.	2nd side	
5	Out Side Diameter	Drg. No.	630 mm - 2nd side 611.7 mm	Step length 9.5
6	Inside Diameter	Drg. No.	520.14 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 mm / 13 x 8 x 5 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		565 mm	Tapping of Hole 212
13	Tapping Hole Diameter		H20 - Check by H20 B. 12	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/9/25

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

1	Counter Sinking Depth & Finish	ok						Counter 60
2	External Relief Dia	4.0 mm	Outside 3-3		Inner			Rev. 35
3	External Relief Depth		12 mm		5 mm			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		16	9	25			

Inspected By (Sign) & Date

Ravi 16/9/25

Reviewed by (Engineer-CNC)

Manager-QA