



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15990	50/55
2	Machined By		V.T.I. M/c Shop	Dry No. 18.2453
3	Pallet Die No.		15466 (8.0) 44	Rev. 00
4	Die Category	Drg. No.	JEN	
5	Out Side Diameter	Drg. No.	740 44	Step oD 743.3 44
6	Inside Diameter	Drg. No.	630.14 44	Tapper. 10"
7	Width of Pellet Die	Drg. No.	290 44	Step length 28 44
8	Grooves as per Drawing	Drg. No.	15x8x5 44 / 15x8x5 44	Under cut 1.7 44
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side Step
10	Drilling Area Surface Smoothness		OK	0.8 44 Deep Bottom
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		685 44	of Holes 18
13	Tapping Hole Diameter		M20	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 44	Tapping depth = 18.4 44
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi	22/9/25	Final Fitting
2	Gun Drilling Work Completed On				Size 12.0.453
3	Hole Finish In Gun Drilling	Marked	OK		Rev. 00
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 26
2	External Relief Dia	2.5 44	Outside 23-25		Inner			Row 2 25
3	External Relief Depth		13 44		5 44			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			22	9	25		

Inspected By (Sign) & Date

					Ravi	22-9-25		
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Reviewed by (Engineer-CNC)

Manager-QA