



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)

10653

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15994	42/42
2	Machined By		V.T.L. H/O Shop	Dy. No. 12.0.0112
3	Pallet Die No.		16056 (B.5)	Rev. No.
4	Die Category	Drg. No.	S&P	
5	Out Side Diameter	Drg. No.	503.9 mm (B) Step 00.	490.9 mm
6	Inside Diameter	Drg. No.	420.14 mm	Step length 13 mm
7	Width of Pellet Die	Drg. No.	182 mm	
8	Grooves as per Drawing	Drg. No.	10x10x5 mm 10x10x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		455 mm	
13	Tapping Hole Diameter		03/16" 2 Check by 03/16" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19.4 mm	Tapping Depth 17.6 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Resi 17/9/25	
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		
2	External Relief Dia	4.0 mm	Outside 2.25	Inner
3	External Relief Depth		4 mm	Mill
4	Inspection Done Before Hardening By (Name)		Resi	
5	Material Sent For Hardening By (Name)		Lark Process	
6	Material Sent For Hardening On Date		17 9 05	
Inspected By (Sign) & Date			Resi 17/9/25	

Reviewed by (Engineer-CNC)

Manager-QA