



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)

Remarks

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15720	34/40
2	Machined By		V.T.I. M/c Shop	Dry No. 1.50.1146
3	Pallet Die No.		15803(2.8)M	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	384.9mm / Step OD = 382.8mm	
6	Inside Diameter	Drg. No.	305.14mm	Step length = 11.5
7	Width of Pellet Die	Drg. No.	144mm	
8	Grooves as per Drawing	Drg. No.	10x8x5mm / 10x8x5mm	
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		350mm	Both Side
13	Tapping Hole Diameter		M16, Check by M16Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4mm	Tapping depth = 19.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25-9-25

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°
Row = 204

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.1mm	Outside 2-25	Inner			
3	External Relief Depth		12mm	6mm			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		25	9	25		

Inspected By (Sign) & Date

Ravi 25-9-25

Reviewed by (Engineer-CNC)

Manager-QA