



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)

10794

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15955 ✓	33/50 ✓
2	Machined By		V.T.I. M/c Shop	Dry No-13d-931
3	Pallet Die No.		15892 (4.0)mm	(Per/00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520. mm - Step OD =	491.9 mm
6	Inside Diameter	Drg. No.	420.14 mm	Step length = 18.5
7	Width of Pellet Die	Drg. No.	160 mm	
8	Grooves as per Drawing	Drg. No.	10x8x5 mm 10x8x5 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		454 mm	of Holes - 8
13	Tapping Hole Diameter		Ø 1/4" = Check by 0.1/4" B/L	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.6 mm	Tapping depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 01/10/25

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 - 2 Hole Colured

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK	outside	Turner	Counter-60°
2	External Relief Dia	4.5 mm	(2-2)	(17 mm)	Row-21
3	External Relief Depth		21 mm		
4	Inspection Done Before Hardening By (Name)			Ravi	
5	Material Sent For Hardening By (Name)			Lark Furnace	
6	Material Sent For Hardening On Date		01	10	25
Inspected By (Sign) & Date				Ravi	01/10/25

Reviewed by (Engineer-CNC)

Manager-QA