



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		16154	36/50
3	Pallet Die No.		V.T.I M/c Shop	Dry No 21:3.0.419
4	Die Category	Drg. No.	14580 (B.O) m	Reason
5	Out Side Diameter	Drg. No.	Mr. Jombar	
6	Inside Diameter	Drg. No.	700 mm Step oD = 692 mm	
7	Width of Pellet Die	Drg. No.	600.14 mm	Step length = 19.5
8	Grooves as per Drawing	Drg. No.	22.2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12.5 x 8 x 7 mm 12.5 x 8 x 7 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	Tapping No
13	Tapping Hole Diameter		645 mm	of Holes = 12
14	Tapping On Second Side	Half pitch of 1st side	M20, Check by M20.14	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 22.4 mm	Tapping depth = 20.4
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

1	As per programme no.		Ravi	03/10/25
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		OK	

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

1	Counter Sinking Depth & Finish	OK							Counter = 30
2	External Relief Dia	23.5 mm	23.3		Inner				Row = 38
3	External Relief Depth	20 mm			14 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				03	10	25		

Inspected By (Sign) & Date

			Ravi	03/10/25
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Reviewed by (Engineer-CNC)

Manager-QA