



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)

10886

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16177	34/50
2	Machined By		V.T.I M/c Shop	Dray No. 1-3.p.405
3	Pallet Die No.		14951(4.0)mm	Ren 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9mm Step OD = 498.8mm	Tapper 12
6	Inside Diameter	Drg. No.	420.14mm	Step length 12mm
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
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		454mm	of Holes = 8
13	Tapping Hole Diameter		03/4" = Check by 03/4" Ball	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.6mm	Tapping depth 216.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 15/10/25

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

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

1	Counter Sinking Depth & Finish	OK	outside	Inner			Counter = 30
2	External Relief Dia	4.5mm	(2-2)				Row = 20
3	External Relief Depth		20mm	16mm			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date			15	10	25	

Inspected By (Sign) & Date

Ravi 15/10/25

Reviewed by (Engineer-CNC)

Manager-QA