



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.		15752 to 16315	40/50
2	Machined By		V.T.I. M/c Shop	Day No. 1-2-18
3	Pallet Die No.		15531 (5.0) mm	Rev. 02
4	Die Category	Drg. No.	See	
5	Out Side Diameter	Drg. No.	519.9 mm	Step OD 2 490.9 mm Step length 17
6	Inside Diameter	Drg. No.	420.14 mm	
7	Width of Pellet Die	Drg. No.	182 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm	12 x 8 x 3 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 2 8
13	Tapping Hole Diameter		M2 x Check by M20 B-12	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 2 18.4 mm Tapping depth 2 16.4 mm	
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		Counter 2 60
2	External Relief Dia	5.5 mm	82-25	Inner
3	External Relief Depth		15 mm	10 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		15 10 25	
Inspected By (Sign) & Date			Ravi 15/10/25	

Reviewed by (Engineer-CNC)

Manager-QA