



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.		16209	23/40
2	Machined By		V.T.I M/c Shop	Dray No. 1-2-1506
3	Pallet Die No.		15675 (5.0) mm	Rev.
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm	Step OD = 478.8 Tapper 12
6	Inside Diameter	Drg. No.	420.14 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12-8-3 mm / 12-8-3 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 = 8
13	Tapping Hole Diameter		12-8-3 mm	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.6 mm	Tapping depth = 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	outside	Inner	Counter 260
2	External Relief Dia	5.5 mm	(2-2)		Row = 17
3	External Relief Depth	13 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