



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.		18174	45/45
2	Machined By		V. T. L. n/c Shop	Drg. No. 18.0.108
3	Pallet Die No.		14906 (B.O) n/c	Rev. no
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	407.9 n/c, Step 02, 383.9 n/c	Step length 10.3
6	Inside Diameter	Drg. No.	318.14 n/c (one side 10.330.14)	
7	Width of Pellet Die	Drg. No.	134 n/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 3 n/c 12.5 x 2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes. 8 Both Side
12	Tapping PCD		350 n/c	
13	Tapping Hole Diameter		1/2" 2 Check by 1/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 16.4 n/c	Tapping Depth 14.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 16/10/25	
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 Boi Ravi 9
2	External Relief Dia	8.5 n/c	Outside 2-2	Inner
3	External Relief Depth		5 n/c	Mill
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		18 10 25	
Inspected By (Sign) & Date			Ravi 16/10/25	

Reviewed by (Engineer-CNC)

Manager-QA