



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.		11525	44/40
2	Machined By		V.T.L N/C Shop	Dy. No. 12.02.474
3	Pallet Die No.		117-51 (4.0) mm	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390.8 mm / Step 00, 387.3 mm / Step length 9.5	
6	Inside Diameter	Drg. No.	311.12 mm / 310.12 (Bar = 311.1)	
7	Width of Pellet Die	Drg. No.	146 mm After Hardening	
8	Grooves as per Drawing	Drg. No.	157.8 x 3 mm / 15 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping dia of holes = 2.8 Both side
12	Tapping PCD		356 mm	
13	Tapping Hole Diameter		2.8 mm = Check by 2.8 mm Bolt	
14	Tapping On Second Side	Half pitch of 1st side	2.8 mm = Check by 1.2 mm Bolt	
15	Tapping Hole Depth		Drill Depth = 19 mm / 20 mm	Tapping Depth = 19.8 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/4/24

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							
2	External Relief Dia	6.5 mm	outside (2-2)						
3	External Relief Depth		4 mm						
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Sony 11/4/24

Inspected By (Sign) & Date

Ravi 11/4/24

Reviewed by (Engineer-CNC)

Manager-QA