



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.		14301	415/50
2	Machined By		V. T. L. N/A Shop	Dryer 13.2.406
3	Pallet Die No.		14173(3.2) N/A	Rever
4	Die Category	Drg. No.	Ext. outside	
5	Out Side Diameter	Drg. No.	62mm Step 02, 62.4	Tapper, 12
6	Inside Diameter	Drg. No.	52.12mm	Step length 13
7	Width of Pellet Die	Drg. No.	22.2mm	Undercut 1.2mm
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	
12	Tapping PCD		56.5mm	Tapping No. of Holes 12
13	Tapping Hole Diameter		N/A Check by N/A Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3mm Tapping Depth 18.6mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24/2/25

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 - 1 Hole Calused

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

1	Counter Sinking Depth & Finish	ok						Counter, 60
2	External Relief Dia	3.5mm	Outside (2-3)		Inner			Lower 32
3	External Relief Depth		1.2mm		5mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark furnace
6	Material Sent For Hardening On Date		24	2	25			

Inspected By (Sign) & Date

Ravi 24/2/25

Reviewed by (Engineer-CNC)

Manager-QA