



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.		15987	28/65
2	Machined By		V.T.L. M/c Shop	Dry No. 1-2-0-093
3	Pallet Die No.		15509 (3.2) mm	Rev 200
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	822.9 mm	Step OD = 822.9 mm
6	Inside Diameter	Drg. No.	700.14 mm	Tapper = 4°
7	Width of Pellet Die	Drg. No.	324 mm	Step length = 33 mm
8	Grooves as per Drawing	Drg. No.	307.8 - 8.5 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		760 mm	of Holes = 12
13	Tapping Hole Diameter		M22 - Check by M22 Ball	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 36.4 mm	Tapping depth = 34 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 01/10/25

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 - 4 Hole Colused

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	4.5 mm	Outside (23-3)		Inner			Raw = 46
3	External Relief Depth		4 mm		37 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			01	10	25		

Inspected By (Sign) & Date

Ravi 01/10/25

Reviewed by (Engineer-CNC)

Manager-QA