



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.		16062	36/50
2	Machined By		V.T.I. M/c Shop	Dry No = 1-2-09780
3	Pallet Die No.		15703(3.0) H-1	Raw = 00
4	Die Category	Drg. No.	2x diamide	
5	Out Side Diameter	Drg. No.	619.9 H-1	Step OD = 12
6	Inside Diameter	Drg. No.	520.14 H-1	Step length = 18.5 H-1
7	Width of Pellet Die	Drg. No.	222 H-1	
8	Grooves as per Drawing	Drg. No.	13x8x5 H-1 / 13x8x5 H-1	
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		565 H-1	of Holes 212
13	Tapping Hole Diameter		H20, Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.5 H-1	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi	22/9/25
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 = 30
2	External Relief Dia	3.5 H-1	Outside (3-3)		Inner			Raw = 28
3	External Relief Depth		20 H-1		14 H-1			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date							

Inspected By (Sign) & Date

			Ravi	22-9-25
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Reviewed by (Engineer-CNC)

Manager-QA