



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.		16088	45/50
2	Machined By		V.T.1 M/c Shop	Dry No. 1-30-370
3	Pallet Die No.		16020 (G.O) M	Rev. 100
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9 M	Step OD = 490.9 M
6	Inside Diameter	Drg. No.	420.14 M	Step length = 19.0 M
7	Width of Pellet Die	Drg. No.	159.5 M	17.5 M
8	Grooves as per Drawing	Drg. No.	13.5 x 8 x 3 M	12 x 8 x 3 M
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		454 M	of Hole = 8
13	Tapping Hole Diameter		0314" = Check by 0314" Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.5 M	Tapping depth = 13.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/9/25

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 = 80
2	External Relief Dia	6.5 M	Outside 82.25		Inner			Row = 15
3	External Relief Depth		11 M		5 M			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			23	9	25		
Inspected By (Sign) & Date			Ravi 23-9-25					

Inspected By (Sign) & Date

Ravi 23-9-25

Reviewed by (Engineer-CNC)

Manager-QA