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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.		14035	30/45/55
2	Machined By		V.T.L. M/c. Shop	Dwg No. 620.340
3	Pallet Die No.		14762 (6.0) HH	Rev. 00
4	Die Category	Drg. No.	M. Turbo	
5	Out Side Diameter	Drg. No.	690 HH, Step OD = 682 HH	Step Length 34.5
6	Inside Diameter	Drg. No.	580.12 HH	Tapper = 12°
7	Width of Pellet Die	Drg. No.	266 HH	
8	Grooves as per Drawing	Drg. No.	28.5x6x12 HH | 28.5x6x12 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		630 HH	[Tapping No of Holes: 12 Both Side]
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 25.2 HH Tapping Depth 23.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 8/3/25	
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 60°	Ravi 25
2	External Relief Dia	6.5HH | 7.0HH	6.5HH	All Rows = 25HH					
3	External Relief Depth		7.0HH	All Rows = 10HH					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		8	3	25				
	Inspected By (Sign) & Date		Ravi 8/3/25						

Satya 8/3/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner