

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Inprocess Inspection (Pellet Dies)

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

9437

Check Parameter	Specification	Observations	Remarks
1 Work Order No.		14417 ✓	32/39 ✓
2 Machined By		V. T. L. n/c Shop	Drg. No. 18.01.937
3 Pallet Die No.		13879 (3.2) n/c	Rev. 2
4 Die Category	Drg. No.	M. J. 10	
5 Out Side Diameter	Drg. No.	678 n/c, Step 002 - 692 n/c	Step length 20 n/c
6 Inside Diameter	Drg. No.	600.12 n/c	Undercut 7 n/c
7 Width of Pellet Die	Drg. No.	265 n/c	
8 Grooves as per Drawing	Drg. No.	15 x 8 x 7 n/c 15 x 8 x 7 n/c	
9 Fitting Sizes on CNC Plate	Drg. No.	ok	
10 Drilling Area Surface Smoothness		ok	
11 Tapping Operator		n/c Shop	[Tapping N. of Holes 16 Both Side]
12 Tapping PCD		640 n/c	
13 Tapping Hole Diameter		M20 - Check by M20 Gage	
14 Tapping On Second Side	Half pitch of 1st side	ok	
15 Tapping Hole Depth		Drill Depth 20.2 n/c	Tapping Depth 18.6
16 Perpendicularity of Tapped Hole		yes	
17 Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 22/3/25

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 - 1 Hole Closed

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

Counter 80°

1 Counter Sinking Depth & Finish	ok						Raw: 35
2 External Relief Dia	3.8 n/c	3.8	All Rows				
3 External Relief Depth			7 n/c				
4 Inspection Done Before Hardening By (Name)			Raw:				
5 Material Sent For Hardening By (Name)			Lark Porrore				
6 Material Sent For Hardening On Date		22	3	25			

Inspected By (Sign) & Date

Raw: 22/3/25

Reviewed by (Engineer-CNC)

Manager-QA