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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14471	35/50
2	Machined By		V.T.L. n/c Shop	Qty 4.0 450
3	Pallet Die No.		13500 (4.0) mm	Recess
4	Die Category	Drg. No.	7810	
5	Out Side Diameter	Drg. No.	730mm / Step 0.2	743.4mm Tap hole
6	Inside Diameter	Drg. No.	630.12 mm	Step length 283mm
7	Width of Pellet Die	Drg. No.	290 mm	End face 68mm
8	Grooves as per Drawing	Drg. No.	15x8x5 mm / 15x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes - 10
12	Tapping PCD		685 mm	Both side
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 mm	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 28/3/25	
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°
2	External Relief Dia	4.5 mm	Outside 23-35	Inner
3	External Relief Depth		19 mm	15 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		28 3 25	
Inspected By (Sign) & Date			Ravi 28/3/25	

Satyam
28/3/25

Reviewed by (Engineer-CNC)

Manager-QA