

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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14368 ✓	19/06
3	Pallet Die No.		V.T.L. H/c Shop	Qty No. 12.0.0.9
4	Die Category	Drg. No.	14738 (B.O.) H/c	Rev 02
5	Out Side Diameter	Drg. No.	N. 7mm ho	
6	Inside Diameter	Drg. No.	680.7 H/c Step on 693 H/c Tapper 8°	
7	Width of Pellet Die	Drg. No.	546.12 H/c (Box 548.4 H/c) Step length 31 H/c	
8	Grooves as per Drawing	Drg. No.	195 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.2 H/c 32.7 x 9.2 H/c	
10	Drilling Area Surface Smoothness		OK	Fore Side Step
11	Tapping Operator		OK	2nd Deep Both Side
12	Tapping PCD		N/c Shop	Tapping No
13	Tapping Hole Diameter		619 H/c	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	H162 Check by H16 Bolt	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 33.2 H/c Tapping Depth 31.6	
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Ravi 30/3/25

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 30
2	External Relief Dia	11.5 H/c		All Rows				Rows 12
3	External Relief Depth			47 H/c				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Porace				
6	Material Sent For Hardening On Date		30	3	25			

Inspected By (Sign) & Date

Ravi 30/3/25

Reviewed by (Engineer-CNC)

Manager-QA