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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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14507	50/50
2	Machined By		V. T. L. H/c Shop	Dy No. 14.0.9980
3	Pallet Die No.		14468 (5.0) H/c	Reamed
4	Die Category	Drg. No.	2x outside	
5	Out Side Diameter	Drg. No.	820 H/c, Step 00, Tapper: 12°	
6	Inside Diameter	Drg. No.	520.12 H/c	Step length: 18.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	[Tapping No. of holes: 12 Both Side]
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		N20, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.2 H/c	Tapping Depth: 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 29/3/25	
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				
1	Counter Sinking Depth & Finish	ok		Counter: 60
2	External Relief Dia	5.5 H/c	Outside 23-35	Inner
3	External Relief Depth		4 H/c	Nil
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrone	
6	Material Sent For Hardening On Date		29	3 25
Inspected By (Sign) & Date			Ravi 29/3/25	

Reviewed by (Engineer-CNC)

Manager-QA