

Lark Engineering Company (India) Pvt. Ltd.

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

9531

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.		13989 to 14579 ✓	36/50 ✓
2	Machined By		UTL m/c Shop	Drg No 12501 (Rev 01)
3	Pallet Die No.		13553 (4.0mm)	
4	Die Category	Drg. No.	m- Jumbo	Stk length 20mm
5	Out Side Diameter	Drg. No.	700mm / 2 step 002 8934	Both side
6	Inside Diameter	Drg. No.	50mm 600.1247	Tapper = 12°
7	Width of Pellet Die	Drg. No.	222mm	Tapping No of
8	Grooves as per Drawing	Drg. No.	12x8x7 / 12x8x7	Hole - 12
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Both side
10	Drilling Area Surface Smoothness		OK	Tapper = 12°
11	Tapping Operator		m/c Shop	
12	Tapping PCD		640mm	
13	Tapping Hole Diameter		m20 checking by m20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 20.5	Tapping depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Mahesh 04/04/25	
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	4.5mm	out side (3-3)	Inner
3	External Relief Depth		18mm	14mm
4	Inspection Done Before Hardening By (Name)		Mahesh	
5	Material Sent For Hardening By (Name)		Lark Finance	
6	Material Sent For Hardening On Date		04 04 25	
Inspected By (Sign) & Date			Mahesh 04/04/25	

Satish 9/4/25

Reviewed by (Engineer-CNC)

Manager-QA