

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)

9546

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14539	40/50/855
3	Pallet Die No.		V.7.6. H/c Shop	Dy. Mr. Lark
4	Die Category	Drg. No.	14483(3.2) H/c	
5	Out Side Diameter	Drg. No.	Outside	
6	Inside Diameter	Drg. No.	619.9 mm, Step on, 611.9 mm, Step length 19.5	
7	Width of Pellet Die	Drg. No.	520.2 mm	
8	Grooves as per Drawing	Drg. No.	222 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 mm, 13x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		565 mm	
14	Tapping On Second Side	Half pitch of 1st side	H20, Check by H20 Ball	Tapping No. of Holes = 12 Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.2 mm	Tapping Depth 18.5
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

Inspected By (Sign) & Date

Ravi: 31/7/25

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 - 2 hole Closed

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

Counter 60
Ravi: 31/7/25

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.8 mm	22.25	Inner			
3	External Relief Depth		16 mm	10 mm			
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date						

Inspected By (Sign) & Date

Ravi: 31/7/25

Reviewed by (Engineer-CNC)

Manager-QA