

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)

9484

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14541	33/40
3	Pallet Die No.		V. T.L. n/c Shop	Dy. H. Lark
4	Die Category	Drg. No.	14535-(3.0) mm	
5	Out Side Diameter	Drg. No.	Sender	
6	Inside Diameter	Drg. No.	499.8 mm Step 00 - 490.9 mm	Step length 17.5
7	Width of Pellet Die	Drg. No.	420.12 mm	
8	Grooves as per Drawing	Drg. No.	158 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	127.87 3 mm / 127.87 9 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20. Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.2 mm	Tapping Depth 18.2 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 31/3/25

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

Counter, Raw

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.3 mm	outside 2.2		inner				
3	External Relief Depth		13 mm		7 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

Raw: 31/3/25

Reviewed by (Engineer-CNC)

Manager-QA