

Lark Engineering Company (India) Pvt. Ltd.

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

Inprocess Inspection (Pellet Dies)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14569 to 14091	38/40
2	Machined By		U.T.L m/c Shop	Tag No. 15062 (Rev 00)
3	Pallet Die No.		14668 (3.0 mm)	
4	Die Category	Drg. No.	Senior	Step Length 18
5	Out Side Diameter	Drg. No.	500mm - 8 top 00-498-88	Both side
6	Inside Diameter	Drg. No.	468mm 420.12 mm	Tapping 12
7	Width of Pellet Die	Drg. No.	258 mm	Tapping No of
8	Grooves as per Drawing	Drg. No.	12x8x3 / 12x8x3	Hole - 8
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Both side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		m/c Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		m20 check by m20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	Tapping depth 16.5
15	Tapping Hole Depth		drill depth 28.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		No	
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	3.5mm	out side 13mm	Inner 7mm
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)		Mahesh	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		04	04 25
Inspected By (Sign) & Date			Mahesh 04/04/25	

Reviewed by (Engineer-CNC)

Manager-QA