

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)

9582

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14339	50/50
2	Machined By		V.T.L. H/c Shop	Dry H/c, L.C. 1376-
3	Pallet Die No.		14957 (8.0) H/c	Rev: 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.8 H/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	[Tapping H/c of holes B Both Side]
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H/c, Check by H/c Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 18.4 H/c	Tapping Depth: 6.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Raw: 8/4/25	
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	8.3 H/c	Outside (2.2)	Inner
3	External Relief Depth		4 H/c	Nil
4	Inspection Done Before Hardening By (Name)		Raw	
5	Material Sent For Hardening By (Name)		Lark Purrace	
6	Material Sent For Hardening On Date		8	4
Inspected By (Sign) & Date			Raw: 8/4/25	