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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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14505	38/50
2	Machined By		V.T.L. w/c Shop	By Mr. 12.9.40
3	Pallet Die No.		14961(8.0)H	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52mm Step 002 499mm Tapped	
6	Inside Diameter	Drg. No.	420.12mm	Step length 12mm
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	10-10-3mm 10x10x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		w/c Shop	Tapping of holes B
12	Tapping PCD		454mm	Back Side
13	Tapping Hole Diameter		02 1/4" Check by 02 1/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3mm Tapping Depth 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi 5/4/25	
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 Bo
2	External Relief Dia	8.5mm	20 Side 2-25	Inner
3	External Relief Depth		20mm	12mm
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Fornore	
6	Material Sent For Hardening On Date		5 4 25	
Inspected By (Sign) & Date			Sasi 5/4/25	

Reviewed by (Engineer-CNC)

Manager-QA