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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14812	40/47
2	Machined By		V.T.L. H/c Shop	Dy. H. L. F. O. 15431
3	Pallet Die No.		12.523 (3.0) H	Rev. CO
4	Die Category	Drg. No.	Ext. & inside	
5	Out Side Diameter	Drg. No.	613.6 H	Step 02, 611.5 H
6	Inside Diameter	Drg. No.	52.12 H	Step length, 19.5
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H / 13 x 8 x 5 H	
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 12
12	Tapping PCD		585 H	Both Side
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 9/4/25	
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	3.5 H	Side (2-3)	Inner
3	External Relief Depth		13 H	7 H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ramesh	
6	Material Sent For Hardening On Date		9 4 25	
Inspected By (Sign) & Date			Ravi 9/4/25	

Reviewed by (Engineer-CNC)

Manager-QA