

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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14631 ✓	19/66
3	Pallet Die No.		V.T.L. n/c Shop	Dr. H. 18.26.9
4	Die Category	Drg. No.	14816 (G.O) n/c	Rev. 03
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.7 mm Step 0.02 693 mm	Tapper 8
7	Width of Pellet Die	Drg. No.	546.12 mm (Bore 548.4 mm)	Step length 31 mm
8	Grooves as per Drawing	Drg. No.	19.5 mm	Lead on C = 2.5 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.2 mm 32 x 7 x 9.2 mm (4 x 2)	
10	Drilling Area Surface Smoothness		OK	[Face Side Step]
11	Tapping Operator		n/c Shop	[2 mm Deep]
12	Tapping PCD		619 mm	[Both Side]
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	[Tapping Holes = 2]
14	Tapping On Second Side	Half pitch of 1st side	OK	[Both Side]
15	Tapping Hole Depth		Drill Depth 33.4 mm	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sao: 15/4/25

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 Bore
2	External Relief Dia	4.5 mm	All Rows						Row 2/2
3	External Relief Depth		47 mm						
4	Inspection Done Before Hardening By (Name)		Sao:						
5	Material Sent For Hardening By (Name)		Lark Porrace						
6	Material Sent For Hardening On Date		15	4	25				

Inspected By (Sign) & Date

Sao: 15/4/25

Reviewed by (Engineer-CNC)

Manager-QA