



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.		14859	48/55
2	Machined By		V.T.L. H/C Shop	1 Drg. 13.0.355
3	Pallet Die No.		13894 (4.0) mm	Rev. 02
4	Die Category	Drg. No.	58570	
5	Out Side Diameter	Drg. No.	629.9 mm Step 02, 612 mm Step 14.3 mm	
6	Inside Diameter	Drg. No.	520.14 mm	
7	Width of Pellet Die	Drg. No.	126 mm	
8	Grooves as per Drawing	Drg. No.	13x8x3 mm 13x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		585 mm	
13	Tapping Hole Diameter		H2 = 2 Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm Tapping Depth 18.5 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 17/4/25

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

Counter 60

1	Counter Sinking Depth & Finish	OK						Raw: 25
2	External Relief Dia	4.5 mm	23-35	Outer	Inner			
3	External Relief Depth		17 mm		13 mm			
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark Perma
6	Material Sent For Hardening On Date			17	4	25		

Inspected By (Sign) & Date

Raw: 17/4/25

Reviewed by (Engineer-CNC)

Manager-QA