

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Inprocess Inspection (Pellet Dies)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

9706

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14766 ✓	36/45 ✓
2	Machined By		V.T.L. M/c Shop	Drg. No. 18.0.044
3	Pallet Die No.		13853 (3.0) ✓	Rev. 2.00
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	610mm, Step 00, 621.5mm	Tabber 12
6	Inside Diameter	Drg. No.	520.12mm	Step length 2.5
7	Width of Pellet Die	Drg. No.	222mm	Under cut 5.7mm
8	Grooves as per Drawing	Drg. No.	13x8x5mm 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c. Shop	Tapping No. of holes = 12
12	Tapping PCD		565mm	Both side
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.5mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 24/4/25	
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		
2	External Relief Dia	3.5mm	3.5mm	Inner
3	External Relief Depth		15mm	9mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		24 4 25	
Inspected By (Sign) & Date			Ravi 24/4/25	

Reviewed by (Engineer-CNC)

Manager-QA