

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.		14716	41/50
2	Machined By		V.T.L. n/c Shop	Dr. H. 12.2.19
3	Pallet Die No.		14413 (3.0) n/c	Rev. 100
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	699.8 mm @ Step 00, 692 mm	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 mm / 12.5 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping Holes
12	Tapping PCD		64.5 mm	of holes 12
13	Tapping Hole Diameter		M20. Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.3 mm Tapping Depth 20.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sai: 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		Counter Bore
2	External Relief Dia	(3.5 mm)	Outside (3.3)	Inner
3	External Relief Depth		1.5 mm	9 mm
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark Ponnace	
6	Material Sent For Hardening On Date		24 4 25	
Inspected By (Sign) & Date			Sai: 24/4/25	

Reviewed by (Engineer-CNC)

Manager-QA