

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)

9497

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14527	55/55
2	Machined By		V.T.L. n/c Shop	14924
3	Pallet Die No.		13593 (5.0) n/c	Rev. 00
4	Die Category	Drg. No.	Ext 24 wide	
5	Out Side Diameter	Drg. No.	630 mm, Step 02, 612 mm	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	130.8 x 5 mm / 13 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M202 Black by H2-Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 21/4/25	
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	5.5 mm	22-25	Row 22
3	External Relief Depth	5 mm	Mill	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porroce	
6	Material Sent For Hardening On Date		2 4 25	
Inspected By (Sign) & Date			Ravi 21/4/25	

Satyam 21/4/25

Reviewed by (Engineer-CNC)

Manager-QA