

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.		14907	33/40/5
2	Machined By		V.T.L. H/c Shop	Day 1st Lark 33/5
3	Pallet Die No.		15073(3.0)mm	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm Step 00. 491mm	Step length 17.5
6	Inside Diameter	Drg. No.	420.12mm	
7	Width of Pellet Die	Drg. No.	157.7mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of holes 8
12	Tapping PCD		454mm	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 19mm Tapping Depth 17mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 30/5/25

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 2 Go
2	External Relief Dia	3.3mm	Outside 2.2mm		Inner			Sen. 24
3	External Relief Depth		13mm		7mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Ramace
6	Material Sent For Hardening On Date		30	5	25			

Inspected By (Sign) & Date

Ravi 30/5/25

Manager-QA

Reviewed by (Engineer-CNC)