

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.			
2	Machined By		15166 ✓	43/50 ✓
3	Pallet Die No.		V.T.L. n/c Step	Drg. H. 1.20.99
4	Die Category	Drg. No.	14806 (4.5) ✓	Rev. 00 ✓
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	619.9 mm Step 00. Tapp. 12°	
7	Width of Pellet Die	Drg. No.	520.14 mm	Step length 18.5
8	Grooves as per Drawing	Drg. No.	22.2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 mm / 13x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Step	
12	Tapping PCD		565 mm ✓	
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 20.4 mm	Tapping Depth 8.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/6/25

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							
2	External Relief Dia	5.0 mm	Outside (3-3)		Inner				
3	External Relief Depth		12 mm		7 mm				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark R. R. R.				
6	Material Sent For Hardening On Date		4		6	25			

Inspected By (Sign) & Date

Ravi 4/6/25

Satish 4/6/25

Reviewed by (Engineer-CNC)

Manager-QA