

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.		15109 ✓	25/50 ✓
2	Machined By		V.T.L. H/c Shop	Drg. No. 1.22.9920
3	Pallet Die No.		14709 (3.0) ✓	Rev. 01
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	619.9 ✓	Step 00. Tappers 12"
6	Inside Diameter	Drg. No.	520.14 ✓	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 ✓ 13x8x5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of H/c 12"
12	Tapping PCD		56.5 ✓	Both Side
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 ✓	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 31/5/25	
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 6.8
2	External Relief Dia	3.5 ✓	28 Side (3)	Inner
3	External Relief Depth		28 ✓	25 ✓
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porreco	
6	Material Sent For Hardening On Date		31/5/25	
Inspected By (Sign) & Date			Ravi 31/5/25	

Reviewed by (Engineer-CNC)

Manager-QA