10:45

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.		15112	35/45/80
2	Machined By		V.T.L M/c Shop	Dy No. 12.9.780
3	Pallet Die No.		15589(6.0) mm	Rev-03
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	730 mm / Step OD: 732 mm / 632 mm	
6	Inside Diameter	Drg. No.	578.14 mm	Step length: 3 mm / 18.5 mm
7	Width of Pellet Die	Drg. No.	219 mm	Undercut: 1 mm
8	Grooves as per Drawing	Drg. No.	75x8x8 mm / 58x8x8 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping M/c of Lulei. B
12	Tapping PCD		650 mm	
13	Tapping Hole Diameter		M16: Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and	Third Side One Side
15	Tapping Hole Depth		Drill Depth. 46.4 mm	Tapping Depth. 38
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 9/6/25	
1	As per programme no.		—	191.1
2	Gun Drilling Work Completed On		—	36.1 mm width
3	Hole Finish In Gun Drilling	Marked	ok	19 mm Deep
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° Row. 8
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm	All Rows	2.45 mm			
3	External Relief Depth		7.0 mm	All Rows	2.35 mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		9	6	25			
	Inspected By (Sign) & Date		Ravi 9/6/25					

Reviewed by (Engineer-CNC) 9/6/25

Manager-QA