

10/01

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.		15201 ✓	40/51 ✓
2	Machined By		V.T.L. N/C Shop	Qty 4, 12.0.1338
3	Pallet Die No.		15470 (2.8) ✓	Rev. 00 ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	732 mm, Step 00, 743 mm, Tapper 4°	
6	Inside Diameter	Drg. No.	630.14 mm	Step Length 27.5
7	Width of Pellet Die	Drg. No.	275 mm	Under cut 5.5 mm
8	Grooves as per Drawing	Drg. No.	22 x 8 x 7 mm / 22 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping 12
12	Tapping PCD		685 mm	of Hole 12
13	Tapping Hole Diameter		22.2, Check by H22 Roll	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 28.4 mm	Tapping Depth 28
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 18/6/25	
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				
1	Counter Sinking Depth & Finish	ok		Counter 60
2	External Relief Dia	3.3 mm	Outside (3-3)	Inner 11 mm
3	External Relief Depth		17 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		18/6/25	
Inspected By (Sign) & Date			Ravi 18/6/25	

Reviewed by (Engineer-CNC)

Manager-QA