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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.		15075	60/25
2	Machined By		V.T.L. n/c Shop	Dr. H. 1.301.5
3	Pallet Die No.		15632 (3.0)	Dr. H. 1.301.5
4	Die Category	Drg. No.	Turn bar	
5	Out Side Diameter	Drg. No.	750 mm Step on 748.4 mm	Tapping 21.5
6	Inside Diameter	Drg. No.	630.14 mm	Step length 23 mm
7	Width of Pellet Die	Drg. No.	265 mm	
8	Grooves as per Drawing	Drg. No.	15 x 8 x 5 mm / 15 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		685 mm	of hole - 16
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Roll Depth 20.4 mm	Tapping Roll 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 21/6/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		n/c - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter 24.5
2	External Relief Dia		no Relief	
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Shri Kishan Parmar	
6	Material Sent For Hardening On Date		21/6/25	
Inspected By (Sign) & Date			Ravi 21/6/25	

Reviewed by (Engineer-CNC)

Manager-QA