10142

Lark Engineering Company (India) Pvt. Ltd.	Form No.	CNC/QA/FM/02
I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)	Rev. No.	01
Inprocess Inspection (Pellet Dies)	Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15207	35/40
2	Machined By		V.T.L M/C Shop	Dy No 18.0 x 80
3	Pallet Die No.		15595 (5.0) mm	Rev. 01
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395 mm Step OD = 388.3 mm Step length 9.5	
6	Inside Diameter	Drg. No.	315.14 mm	
7	Width of Pellet Die	Drg. No.	145 mm	
8	Grooves as per Drawing	Drg. No.	7.5x 7.5x 4 mm / 7.5x7.5x4 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No of Holes. Both Side
12	Tapping PCD		355 mm / 360 mm	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one Side Tapping 03/4" and IInd Side 01/2"	
15	Tapping Hole Depth		Drill Depth. 18.8 mm / 16 mm Tapping Depth 17 mm	13.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 23/6/25	
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. Bo

1	Counter Sinking Depth & Finish	ok						Bore = 16
2	External Relief Dia	5.5 mm	outside 23.2		Inner			
3	External Relief Depth		10 mm		5 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		23	6	25			
	Inspected By (Sign) & Date		Ravi 23/6/25					

23/6/25

Reviewed by (Engineer-CNC)

Manager-QA