10205

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.		15356	45/50
2	Machined By		V.T.L. H/C Shop	Dy No. L.E.C/13 76-
3	Pallet Die No.		15308(6.0)	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9 mm, Step OD: 491 mm, Step length 17.5	
6	Inside Diameter	Drg. No.	420.14 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm / 12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of Holes 8 Both Side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 : Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth : 18.4 mm	Tapping Depth 15.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 4/7/25	
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 Sink Bore Rev. 15

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	6.5 mm	Outside (2x2)		Inner			
3	External Relief Depth		11 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		4	7	25			
	Inspected By (Sign) & Date		Ravi 4/7/25					

4/7/25

Reviewed by (Engineer-CNC)

Manager-QA