

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10154

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.		15283	30/40/66
2	Machined By		V. T. L. H/c Shop	33/43/66
3	Pallet Die No.		15/66 (G.O) H/c	By who 12.0.08
4	Die Category	Drg. No.	H. 70 mm	Rev 08
5	Out Side Diameter	Drg. No.	680.7 mm	Step 00. 673 mm
6	Inside Diameter	Drg. No.	546.14 mm (B. 543.4)	Step length 31
7	Width of Pellet Die	Drg. No.	195 mm	Exter. ext. 2.5
8	Grooves as per Drawing	Drg. No.	32.779.2 mm	32.779.2 mm (4.28)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side
10	Drilling Area Surface Smoothness		OK	Step 2 mm
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 mm	Tapping H/c
13	Tapping Hole Diameter		M162	of 4.0 mm
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 mm	Tapping Depth
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/5/25

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	
2	External Relief Dia	6.5 mm 9.0 mm	Just Rad
3	External Relief Depth	6.5 mm All Rows 2.26	7.0 mm All Rows 2.26
4	Inspection Done Before Hardening By (Name)		Ravi
5	Material Sent For Hardening By (Name)		Lark Furnace
6	Material Sent For Hardening On Date	28	6 25

Inspected By (Sign) & Date

Ravi 28/9/25

Reviewed by (Engineer-CNC)

Manager-QA