

Lark Engineering Company (India) Pvt. Ltd.

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

10321

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.			
2	Machined By		15494	55/66
3	Pallet Die No.		V.7.L n/c Shop	Qty 12.0.32
4	Die Category	Drg. No.	15553(8.0)H	Rev. 08
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.14mm Shop 00.692.9mm Tapper 8"	
7	Width of Pellet Die	Drg. No.	546.14mm (Box 548.8)mm	Stick length 8"
8	Grooves as per Drawing	Drg. No.	195mm	Undercut 8.8"
9	Fitting Sizes on CNC Plate	Drg. No.	32.8 x 9.1mm 32.8 x 9.1mm (4 x 2)mm	
10	Drilling Area Surface Smoothness		ok	Face side stick
11	Tapping Operator		ok	2mm Deep
12	Tapping PCD		n/c Shop	Both Side
13	Tapping Hole Diameter		619mm	Tapping H.
14	Tapping On Second Side	Half pitch of 1st side	H16 Check by H16 Bolt	of H16.2
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.6mm Tapping Depth 31.6	
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Rao: 23/7/25

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

Counters 20

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	9.0mm		All Rows					
3	External Relief Depth			11mm					
4	Inspection Done Before Hardening By (Name)			Rao!					
5	Material Sent For Hardening By (Name)			Lark Purnore					
6	Material Sent For Hardening On Date			23	7	25			

Inspected By (Sign) & Date

Rao: 23/7/25

Manager-QA

Reviewed by (Engineer-CNC)