



Lark Engineering Company (India) Pvt. Ltd.

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

10419

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		15504	36/50
3	Pallet Die No.		V.T.L. H/c Shop	Drg. No. 1.20.9980
4	Die Category	Drg. No.	15014 (3.0) mm	Rev. 100
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	62.44 - Step 00. Tappet = 12	
7	Width of Pellet Die	Drg. No.	52.14 mm	Step length = 18.5
8	Grooves as per Drawing	Drg. No.	222 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13.8 x 5 mm / 13.8 x 5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		565 mm	
14	Tapping On Second Side	Half pitch of 1st side	H20. Crack by 42 Bolt	[Tapping No of holes 12] [Both Side]
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.4 mm	Tapping Depth = 18.4
17	Visual Inspection Before Gun Drilling		yes	
			ok	
Inspected By (Sign) & Date			Ravi 5/8/25	
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		Counter B. Ravi 38
2	External Relief Dia	3.5 mm	Outside (3-3)	Inner
3	External Relief Depth		20 mm	14 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porroice	
6	Material Sent For Hardening On Date		5 8 25	
Inspected By (Sign) & Date			Ravi 5/8/25	

Satya 5/8/25

Reviewed by (Engineer-CNC)

Manager-QA