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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.		15960	45/52
2	Machined By		V.T.L M/c Shop	Dray No. 13d. 1432
3	Pallet Die No.		15483 (9.5) mm	Rev (00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	703.8 mm	Step OD 4694. Step Length - 2
6	Inside Diameter	Drg. No.	600.14 mm	
7	Width of Pellet Die	Drg. No.	992 mm	
8	Grooves as per Drawing	Drg. No.	12x8x7 / 12x8x7	Tapping 12
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		640 mm	of Holes - 12
13	Tapping Hole Diameter		M. 20 Check by H. 20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 22.4 mm	Tapping depth. 22.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 10/9/25	
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	outside	Counter - 60
2	External Relief Dia	Ø (5.0) mm	(3-3)	Row - 28
3	External Relief Depth		11 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		10 9 25	
Inspected By (Sign) & Date			Ravi 10/9/25	

Counter - 60
Row - 28

Inspected By (Sign) & Date

Ravi

10/9/25

Reviewed by (Engineer-CNC)

Manager-QA