

Lark Engineering Company (India) Pvt. Ltd.

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

10637

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		15922	45/50
3	Pallet Die No.		V.T.L M/c Shop	Dry No - 100
4	Die Category	Drg. No.	15441 (3.5) mm	
5	Out Side Diameter	Drg. No.	9 extra wide	
6	Inside Diameter	Drg. No.	619.9 mm Step OD = 611.9 mm	
7	Width of Pellet Die	Drg. No.	520.14 mm	Step length = 19.5
8	Grooves as per Drawing	Drg. No.	222 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13 x 8 x 5 mm / 13 x 8 x 5 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	Tapping No of Holes = 12
13	Tapping Hole Diameter		565 mm	Both Side
14	Tapping On Second Side	Half pitch of 1st side	420 - Check by 42 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 20.5 mm Tapping Depth = 18.4	
17	Visual Inspection Before Gun Drilling		yes	
Inspected By (Sign) & Date			OK	
			Ravi	13/9/25
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	4.0 mm	(3-3)	Inner
3	External Relief Depth		12 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		13 9 25	
Inspected By (Sign) & Date			Ravi	13/9/25

Counter - 60°

Row = 35

Satish
13/9/25

Reviewed by (Engineer-CNC)

Manager-QA