

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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

10659

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15969	42/50
2	Machined By		V.T.I. H/c Shop	Dry No. Lec-9980
3	Pallet Die No.		14861 (4.5) mm	(Rev.00)
4	Die Category	Drg. No.	Extrawind	
5	Out Side Diameter	Drg. No.	619.9 mm	Step 00. Taper 12°
6	Inside Diameter	Drg. No.	520.14 mm	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 mm	Tapping No. of Holes 212
13	Tapping Hole Diameter		M20 Check by M20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 mm	Tapping depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 16/9/25

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

Counter-60°

1	Counter Sinking Depth & Finish	OK	outside	Tuner				Row 229
2	External Relief Dia		(3-3)	8mm				
3	External Relief Depth		13 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			16	9	25		

Inspected By (Sign) & Date

Ravi 16/9/25

Reviewed by (Engineer-CNC)

Manager-QA