

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)

10704

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15958	35/40/2199
2	Machined By		N.T.L. n/c Shop	Dy. H. Lark
3	Pallet Die No.		13947 (3.5)	Rev. 1.00
4	Die Category	Drg. No.	3210	
5	Out Side Diameter	Drg. No.	500 mm Step 00. 490.9 mm	
6	Inside Diameter	Drg. No.	420.14 mm	Step length 14.5
7	Width of Pellet Die	Drg. No.	182 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm / 12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		454 mm	g holes - 8
13	Tapping Hole Diameter		M20. Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.5 mm	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 22/9/25	
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		Counter 28
2	External Relief Dia	4.0 mm	22.25	Inner
3	External Relief Depth		8 mm	5 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Rumar	
6	Material Sent For Hardening On Date		22 9 25	
Inspected By (Sign) & Date			Ravi 22/9/25	

Reviewed by (Engineer-CNC)

Manager-QA