



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)

10235

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16050	45/55
2	Machined By		V.T.I M/c Shop	Dray No 2-13-2410
3	Pallet Die No.		15536 (8.0)mm	Rev 201
4	Die Category	Drg. No.	SSS70	
5	Out Side Diameter	Drg. No.	629.9	Step OD 2629.9mm
6	Inside Diameter	Drg. No.	520.14mm	Tapping 12"
7	Width of Pellet Die	Drg. No.	186mm	Step length 18mm
8	Grooves as per Drawing	Drg. No.	13x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm	Tapping No of Hole 212
13	Tapping Hole Diameter		H202 Check by H202 Ball	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill depth 220.4mm	Tapping depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24-9-25

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 280 Row 214

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	8.5mm	Outside (8.3-8.7)	Inner			
3	External Relief Depth		18mm	10mm			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date			24	9	25	

Inspected By (Sign) & Date

Ravi 24-9-25

Reviewed by (Engineer-CNC)

Manager-QA