

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.			
2	Machined By		16142	31/50/
3	Pallet Die No.		V.T.I M/C Shop	Day No 2 (Date 29/7)
4	Die Category	Drg. No.	15828 (2.8) M	
5	Out Side Diameter	Drg. No.	Per side	
6	Inside Diameter	Drg. No.	619.9 M	Step OD = 811.9 M
7	Width of Pellet Die	Drg. No.	520.14 M	Step length 19.5
8	Grooves as per Drawing	Drg. No.	222 M	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 M / 13x8x5 M	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/C Shop	Tapping No
13	Tapping Hole Diameter		565 M	of Holes = 12
14	Tapping On Second Side	Half pitch of 1st side	M2 = Check by M2 Bolt	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 20.4 M	Tapping depth = 18.4
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

1	As per programme no.		Ravi	29/9/25
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 = 65
2	External Relief Dia	3.2 M	Outside (23-3)		Inner			Ravi = 40
3	External Relief Depth		22 M		19 M			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark furnace			
6	Material Sent For Hardening On Date			29	9	25		

Inspected By (Sign) & Date

			Ravi	29/9/25
--	--	--	------	---------

Reviewed by (Engineer-CNC)

Manager-QA