10286

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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16128	42/45
2	Machined By		V.T.L. N/C Shop	Drg No. 18.01956
3	Pallet Die No.		15888 (6.0) mm	Revised
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510 mm, Step OD. 491.9 mm	
6	Inside Diameter	Drg. No.	420.14 mm	Step length 13.5
7	Width of Pellet Die	Drg. No.	152 mm	
8	Grooves as per Drawing	Drg. No.	11x5x3 mm / 11x5x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No of holes 8 Both Side
12	Tapping PCD		456 mm	
13	Tapping Hole Diameter		Ø3/4" - Check by Ø3/4" Roll	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 16.4 mm	Tapping Depth 14.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 30/9/25	
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. Go

1	Counter Sinking Depth & Finish	ok						Ring = 15
2	External Relief Dia	6.5 mm	Outside (Ø-2)		Inner			
3	External Relief Depth		9 mm		3 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		30	9	25			
	Inspected By (Sign) & Date		Ravi 30/9/25					

Satish 30/9/25

Reviewed by (Engineer-CNC)

Manager-QA