

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)

10082

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14869	40/45
2	Machined By		V.T.L. M/C Shop	Dr. H. L. D. 297
3	Pallet Die No.		15773 (3.0) M	Rev. 2013
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790 M	Step 00. 800 M
6	Inside Diameter	Drg. No.	700.12 M	Tabber 4°
7	Width of Pellet Die	Drg. No.	320 M	Step length 27 M
8	Grooves as per Drawing	Drg. No.	25x10x9 M	Under cut 5 M
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C	
12	Tapping PCD		7150 M	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	Tapping Holes 12
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 35.4 M	Tapping Depth 33.
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/6/25

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 - 2 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 M	outside (2-3)		Inner				
3	External Relief Depth		11 M		5 M				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		14	6	25				

Inspected By (Sign) & Date

Ravi 14/6/25

Reviewed by (Engineer-CNC)

Manager-QA