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Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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		16037 ✓	30/50 ✓
3	Pallet Die No.		V. T. L. H/c. Shop	6255
4	Die Category	Drg. No.	15407 (3.5) H	100% Lark 350
5	Out Side Diameter	Drg. No.	Ext 29.4mm	
6	Inside Diameter	Drg. No.	619.9mm Step 00.611.9mm Step length 19.5	
7	Width of Pellet Die	Drg. No.	52.14mm	
8	Grooves as per Drawing	Drg. No.	222mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm / 13x8x5mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c. Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4mm Tapping Depth 18.4	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 19/9/25	
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		Count on 60
2	External Relief Dia	4.0mm	Outside (2-3)	Inner
3	External Relief Depth		24mm	20mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		19/9/25	
Inspected By (Sign) & Date			Ravi 19/9/25	

Reviewed by (Engineer-CNC)

Manager-QA