

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.		16146	55/60
2	Machined By		V. T. C. M/C Shop	By Hg 12.01.13
3	Pallet Die No.		15515 (5.0) M/C	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	72mm Step 00. 69mm	Tapper 12
6	Inside Diameter	Drg. No.	600.14mm	Step length 2mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7mm / 12 x 8 x 7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		64mm	Tapping Holes of holes 12
13	Tapping Hole Diameter		M20. Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	Tapping Depth 20mm
15	Tapping Hole Depth		Drill Depth 22.4mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 29/9/25	
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		Counter 60
2	External Relief Dia	5.5mm	Outside (3-3)	Inner
3	External Relief Depth		10mm	5mm
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