



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8898

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		13676	44/50
3	Pallet Die No.		V.T.L n/c Shop	Drg No. 1302/101
4	Die Category	Drg. No.	13884 (4.0) n/c	Rev. 00
5	Out Side Diameter	Drg. No.	⊙ Junior	
6	Inside Diameter	Drg. No.	402mm Step 002 381.3mm / 380.7mm Step length 10.5	
7	Width of Pellet Die	Drg. No.	303.1mm / 304.12mm (Bore 304mm) ⊙	
8	Grooves as per Drawing	Drg. No.	95mm	Discuss with NCCM
9	Fitting Sizes on CNC Plate	Drg. No.	9x6x2.5mm / 9x6x2mm ⊙	with NCCM
10	Drilling Area Surface Smoothness		ok	Sir
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of Holes, 10 Rotu Side
13	Tapping Hole Diameter		350mm	
14	Tapping On Second Side	Half pitch of 1st side	M14 Check by M14 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 15.2mm Tapping Depth 13.5	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 4/1/25

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 = 30
2	External Relief Dia	4.5mm	outside (2-2)		Inner			Row = 11
3	External Relief Depth		14mm		6mm			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							Lark Luxance
6	Material Sent For Hardening On Date			4	1	25		

Inspected By (Sign) & Date

Ravi 4/1/25

Reviewed by (Engineer-CNC) *Jat* 4/1/25

Manager-QA