



Lark Engineering Company (India) Pvt. Ltd.

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

9104

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.		14061 ✓	31/10 ✓
2	Machined By		V.T.L. N/A Shop	Drg No. 620-15062
3	Pallet Die No.		13503 (2.8) ✓	Rev. 00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm, Step 00, 498.88	Tapper = 12°
6	Inside Diameter	Drg. No.	420.12 mm	Step length = 8 mm
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm 12x8x3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	Tapping No. of holes = 8 Both Side
12	Tapping PCD		454 mm ✓	
13	Tapping Hole Diameter		check by H20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 mm Tapping Depth 16.8 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 30/1/25

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							Counter G Row = 26
2	External Relief Dia	3.1 mm	outside 22-25		inner				
3	External Relief Depth		15 mm		9 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	1	25				

Inspected By (Sign) & Date

Ravi 30/1/25

30/1/25

Reviewed by (Engineer-CNC)

Manager-QA