



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)

9508

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14556	38/55
2	Machined By		V.T.L n/c Shop	Dr. No. 18.9.198
3	Pallet Die No.		13000 (5.0) mm	Rev. no.
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	529.8 mm Step 00: 490.6 mm Step length 17	
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	187 mm	
8	Grooves as per Drawing	Drg. No.	12 x 7 x 3 mm / 12 x 7 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		Ø3/4" - Check by Ø3/4" Bolt	Tapping of Holes 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 mm Tapping Depth 18.6 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Signature: 2/4/25

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 Go
2	External Relief Dia	5.5 mm	Outside 22.2	Inner				22
3	External Relief Depth		22 mm	17 mm				
4	Inspection Done Before Hardening By (Name)							Signature
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		2	4	25			

Inspected By (Sign) & Date

Signature: 2/4/25

Reviewed by (Engineer-CNC)

Manager-QA