



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)

9590

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14454	80/85
2	Machined By		V.T.L. H/A Shop	Dr H. 1.2.0. 127
3	Pallet Die No.		14912 (10.0) H/A	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	730mm Step 00.693mm	Tapber. 12
6	Inside Diameter	Drg. No.	600.12mm	Step length 12mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	12x8x7mm / 12x8x7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/A Shop	
12	Tapping PCD		640mm	
13	Tapping Hole Diameter		H 20. Check by H20 Bolt	[Tapping H of holes 12 Both side]
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/4/25

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

Counter 60
Rev 13

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	10.5mm	88.35	Inner			
3	External Relief Depth		12mm	5mm			
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		8	4	25		

Inspected By (Sign) & Date

Ravi 8/4/25

Reviewed by (Engineer-CNC)

Manager-QA