



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)

9526

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14505	34/50
2	Machined By		V.T.L. n/a Shop	Py 18.0 = 405
3	Pallet Die No.		14960 (4.0) n/a	Rev 2 m
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm, 8 step 0.0, 499 mm, Tappet	25
6	Inside Diameter	Drg. No.	420.12 mm (Bor Tappet) 8 step length	17 mm
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	10x10x3 mm 10x10x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		0314" = Check by 0314" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 mm Tapping Depth 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 5/11/25

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	4.5 mm	Outside (2-2)			Inner				Rev 20
3	External Relief Depth		20 mm			16 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		5	4	25					
Inspected By (Sign) & Date			Ravi 5/11/25							

Reviewed by (Engineer-CNC)

Manager-QA