



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)

9244

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14746	50/50
2	Machined By		V.T.L. H/c Shop	Drg H. 1.25.1378
3	Pallet Die No.		15106 (8.0) H	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H, Step 00, 491 H	Step length 12.5
6	Inside Diameter	Drg. No.	420.12 H	
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12-8-3 H 12-8-3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 H	Tapping Depth 16.6 H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rao: 11/5/25	
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		
2	External Relief Dia	8.5 H, 2.25	Outside	Inner
3	External Relief Depth	4 H	Null	
4	Inspection Done Before Hardening By (Name)		Rao	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		1 5 25	
Inspected By (Sign) & Date			Rao: 11/5/25	

Consider 60°
Rev. 12

Reviewed by (Engineer-CNC)

Manager-QA