



Lark Engineering Company (India) Pvt. Ltd.

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

9909

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.		14940	40/60
2	Machined By		V. T. L. n/c Shop	Drg. No. 18.2
3	Pallet Die No.		14157 (G.O) n/c	Rev. no
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	719.9 mm, St. ch. 00. 691.9 mm, St. ch. length. 19.5	
6	Inside Diameter	Drg. No.	600.12 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	36 x 10 x 7 mm / 36 x 10 x 7 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		645 mm	
13	Tapping Hole Diameter		M20. Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.3 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Resi 20/5/25

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 - 1 Hole Colused	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok								Counter Sinking
2	External Relief Dia	7.0 mm		All Rows						Row 18
3	External Relief Depth			20 mm						
4	Inspection Done Before Hardening By (Name)			Resi						
5	Material Sent For Hardening By (Name)			Lark Perware						
6	Material Sent For Hardening On Date			20	5	25				

Inspected By (Sign) & Date

Resi 20/5/25

Satya 20/5/25
Reviewed by (Engineer-CNC)

Manager-QA