



Lark Engineering Company (India) Pvt. Ltd.

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

9958

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.		14951	28/50
2	Machined By		V. T. L. H/C Shop	Dy No. 13.02.944
3	Pallet Die No.		14801 (28) H/C	Renewal
4	Die Category	Drg. No.	H7C H	
5	Out Side Diameter	Drg. No.	700 mm Shop 00.692 mm	Step length 19.8
6	Inside Diameter	Drg. No.	600.14 mm	
7	Width of Pellet Die	Drg. No.	265.6 mm	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 7 mm / 15.3 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step
10	Drilling Area Surface Smoothness		ok	0.8 mm Deep Both side
11	Tapping Operator		H/C Shop	Tapping No.
12	Tapping PCD		640 mm	of holes 16
13	Tapping Hole Diameter		H202 Check by H202 B.1	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.7 mm Tapping Depth 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/5/25

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 Closed

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

Count on 260

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3 mm	Outside 23-31	Inner					Count on 269
3	External Relief Depth		25 mm	20 mm					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Pernane
6	Material Sent For Hardening On Date		26	5	25				

Inspected By (Sign) & Date

Ravi 28/5/25

Satya 26/5/25

Reviewed by (Engineer-CNC)

Manager-QA