



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15215	33/43/60
2	Machined By		V.T.L. H/c Stop	Qty 4, L&Q. 354
3	Pallet Die No.		14158	Rev. 100
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	719.9 mm Stop	392 mm Step length 19.5
6	Inside Diameter	Drg. No.	600.14 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	36x10x7 mm / 36x10x7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Stop	Tabbing No. of Holes. 12
12	Tapping PCD		645 mm	Both Side
13	Tapping Hole Diameter		H202 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tabbing Depth 18
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 3/8/25

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 - Hole Calculated

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

Counter 60

1	Counter Sinking Depth & Finish	OK								Ravi 18
2	External Relief Dia	2.5 mm / 7.0 mm	6.5 mm	All Rows 2	27 mm					
3	External Relief Depth		7.0 mm	All Rows 2	17 mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Ravi
6	Material Sent For Hardening On Date			3	7	25				

Inspected By (Sign) & Date

Ravi 3/8/25

Satya 31/7/25

Reviewed by (Engineer-CNC)

Manager-QA