



Lark Engineering Company (India) Pvt. Ltd.

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

10090

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.			
2	Machined By		15106 ✓	58/66
3	Pallet Die No.		V.T.C. n/c Shop	60/66
4	Die Category	Drg. No.	15219(9.0) n/c	Dry Hole 62.0239
5	Out Side Diameter	Drg. No.	4.7 mm	Rev. 08
6	Inside Diameter	Drg. No.	680.1 mm Step 00.893 mm	Tipper. 8"
7	Width of Pellet Die	Drg. No.	546.14 mm (Rev. 548.2 mm)	Step length 314
8	Grooves as per Drawing	Drg. No.	195 mm	End of 31.8 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32+7+9.1 mm / 32+7+9.1 mm (4+8) mm	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		ok	8 mm Deep
12	Tapping PCD		n/c Shop	Back Side
13	Tapping Hole Diameter		619 mm	Tapping No.
14	Tapping On Second Side	Half pitch of 1st side	HIG. Check by HIG Bolt	of holes. 2
15	Tapping Hole Depth		ok	Back Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.4 mm	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Sasi 16/8/25

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

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

Counter. 60

1	Counter Sinking Depth & Finish	ok							Rev. 8
2	External Relief Dia	10.0 mm	1st Pad 8 mm	2nd Pad 6 mm					
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)		Sasi						
5	Material Sent For Hardening By (Name)		Lark Parnace						
6	Material Sent For Hardening On Date		16	8	25				

Inspected By (Sign) & Date

Sasi 16/8/25

Reviewed by (Engineer-CNC)

Manager-QA