



Lark Engineering Company (India) Pvt. Ltd.

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

10150

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		15251 ✓	3-105 ✓
3	Pallet Die No.		V.T.L. n/c Shop	Day No. 18.2.917
4	Die Category	Drg. No.	15313(3.5)mm	Rev 2.00
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	790mm, Step no 2 792mm, Step length 20.5	
7	Width of Pellet Die	Drg. No.	660.14mm	Under cut - 1mm
8	Grooves as per Drawing	Drg. No.	324mm	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 8mm / 21.5 x 8 x 8mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		725mm	
14	Tapping On Second Side	Half pitch of 1st side	H20. Check by H20 Bolt	Tapping Ho of Holes - 12 Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth. 31.4mm Tapping Depth. 29.5	
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Savi 24/8/25

1	As per programme no.				2 Slot
2	Gun Drilling Work Completed On				32.1mm machined
3	Hole Finish In Gun Drilling	Marked			8mm Deep
4	Defective Holes (If Any)		ok		Both Side
			No - Hole Colused		

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

Counter Sink

1	Counter Sinking Depth & Finish	ok							Row 51
2	External Relief Dia	4.0mm	Outside 13-27		Inner				
3	External Relief Depth		12mm		5mm				
4	Inspection Done Before Hardening By (Name)				Savi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		24	6	25				

Inspected By (Sign) & Date

Savi 24/8/25

Reviewed by (Engineer-CNC)

Manager-QA