



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.		15159	30/04/13
2	Machined By		N.T.L. H/C Shop	Dy. No. 1.8.032
3	Pallet Die No.		15371 (6.5) mm	Rever
4	Die Category	Drg. No.	H.T. Umba	
5	Out Side Diameter	Drg. No.	636 mm / 632 mm	630.4 mm / 543 mm
6	Inside Diameter	Drg. No.	480.12 mm / 489 mm / 500.12	Step length 1.8 mm
7	Width of Pellet Die	Drg. No.	192 mm	18.5 mm
8	Grooves as per Drawing	Drg. No.	37 x 12 x 8 x 9.5 mm / 27 x 12 x 8 x 9.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping 1.7
12	Tapping PCD		540 mm	of 1.6 x 4
13	Tapping Hole Diameter		H16. Check by H16 B.1	
14	Tapping On Second Side	Half pitch of 1st side	one Side Tapping and 1st Side One Set	
15	Tapping Hole Depth		Drill Depth 29 mm Tapping Depth 29 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 23/06/25	1.810
1	As per programme no.			28.1 mm
2	Gun Drilling Work Completed On			Width 2.12 mm
3	Hole Finish In Gun Drilling	Marked	OK	Deep
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Count 2.03
2	External Relief Dia	7.0 mm / 7.5 mm	7.0 mm All Rows 2	42 mm
3	External Relief Depth		7.5 mm All Rows	14 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lank Ravi	
6	Material Sent For Hardening On Date		23 6 25	
Inspected By (Sign) & Date			Ravi 23/06/25	

Reviewed by (Engineer-CNC)

Manager-QA