



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)

10203

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14976	60/65
2	Machined By		V. T. L. N/C Shop	Dy H. 14.02.95
3	Pallet Die No.		15818 (4.5)	Revised
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	549.9 mm Step 00.491 mm Step length 7.5	
6	Inside Diameter	Drg. No.	420.14 mm (10.420.4)	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12.8 x 3 mm / 12.8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping 4
12	Tapping PCD		454 mm	of hole 8
13	Tapping Hole Diameter		H202 Check by H2 B-1	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.6 mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/7/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		Nil

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

1	Counter Sinking Depth & Finish	OK						Counter Bo
2	External Relief Dia	5.0 mm	Outside (2-2)		Inner			Row 18
3	External Relief Depth		14 mm		5 mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porroce
6	Material Sent For Hardening On Date			3	7	25		

Inspected By (Sign) & Date

Ravi 31/8/25

Reviewed by (Engineer-CNC)

Manager-QA