



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)

10202

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14976	Bo/65
2	Machined By		V. T. L. n/c Shop	1 Day 4.13.0 = 95
3	Pallet Die No.		15819(4.5) n/c	Renzo
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	550 mm, Step 00-471 mm	Step length 17.5
6	Inside Diameter	Drg. No.	420.14 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12-8-3 mm 12-8-3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		454 mm	of hole 8
13	Tapping Hole Diameter		M2, Check by M2 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 18.6 mm	Tapping Depth. 18.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 3/7/25

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

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

1	Counter Sinking Depth & Finish	ok						Counter. 60°
2	External Relief Dia	5.0 mm	0.025		Inner			Ravi 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 Rurnace			
6	Material Sent For Hardening On Date				3	7	25	

Inspected By (Sign) & Date

Ravi 3/7/25

Reviewed by (Engineer-CNC)

Manager-QA