



Lark Engineering Company (India) Pvt. Ltd.

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

10266

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		15337	39/70
3	Pallet Die No.		V.T.L. n/c Shop	Drg. No. L2012102
4	Die Category	Drg. No.	14229 (B.O.)	Rev. 01
5	Out Side Diameter	Drg. No.	S. Jumbo	
6	Inside Diameter	Drg. No.	1287 mm Step 00. 1283 mm	Step length 98
7	Width of Pellet Die	Drg. No.	1145.14 mm	
8	Grooves as per Drawing	Drg. No.	388.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	26 x 6 x 13.1 mm / 28 x 6 x 13.1 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		N/c Shop	Tapping No. of holes 20
13	Tapping Hole Diameter		1210 mm	Both Side
14	Tapping On Second Side	Half pitch of 1st side	M24 Check by M24 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 33.4 mm	Tapping Depth 31.4
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Rao: 14/7/25

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

Counter 60
Row 69

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	3.8 mm	24-45	Inner				
3	External Relief Depth		37 mm	31 mm				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		14	7	25			

Inspected By (Sign) & Date

Rao: 14/7/25

Reviewed by (Engineer-CNC)

Manager-QA