



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)

10281

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15440	30/50
2	Machined By		V. T. L. n/a Shop	Drg. No. 12.0419
3	Pallet Die No.		14507 (4.0) mm	Rev. 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 mm	Step 00. 691.9 mm
6	Inside Diameter	Drg. No.	600.14 mm	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 mm	12.5 x 8 x 7 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/a Shop	Tapping 4.0
12	Tapping PCD		645 mm	of holes 12
13	Tapping Hole Diameter		M20 Crack by M20 B.1	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 22.4 mm	Tapping Depth 22.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rao: 16/7/25	
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 - 1 Hole Colused	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter: 6-
2	External Relief Dia	4.5 mm	Outside (3-3)	Rev: 32
3	External Relief Depth		24 mm	Inner 20 mm
4	Inspection Done Before Hardening By (Name)		Rao	
5	Material Sent For Hardening By (Name)		Lark Porroce	
6	Material Sent For Hardening On Date		16 7 25	
Inspected By (Sign) & Date			Rao: 16/7/25	

Signature
16/7/25

Reviewed by (Engineer-CNC)

Manager-QA