



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)

10323

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15493 ✓	35/4/66
3	Pallet Die No.		V.T.L. n/c Shop	Dy. No. P. 30
4	Die Category	Drg. No.	15545 (B.0) ✓	Rev. 03
5	Out Side Diameter	Drg. No.	M. Jom bo	
6	Inside Diameter	Drg. No.	680.7 mm, Step 00, 692.8 mm, Taper 8	
7	Width of Pellet Die	Drg. No.	546.12 mm (Bar - 548.4 mm) Step length 31 mm	
8	Grooves as per Drawing	Drg. No.	195 mm	Order cut 2.5 mm
9	Fitting Sizes on CNC Plate	Drg. No.	327.7 ± 0.2 mm / 327.7 ± 0.2 mm (4 ± 8) mm	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		ok	2 mm Raab
12	Tapping PCD		n/c Shop	Both Side
13	Tapping Hole Diameter		619 mm ✓	Tapping H.
14	Tapping On Second Side	Half pitch of 1st side	NIS, Check by NIS B-11	of holes 2
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.6 mm	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 22/7/25

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 Bo

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm	All Rows 231 mm ✓					
3	External Relief Depth		7.0 mm	All Rows 226 mm ✓					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		22	7	25				

Inspected By (Sign) & Date

Ravi 22/7/25

Reviewed by (Engineer-CNC)

Manager-QA