



Lark Engineering Company (India) Pvt. Ltd.

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

10399

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.		15594	53/53
2	Machined By		V.T.L. H/c Shop	Qty 120/20
3	Pallet Die No.		14280 (3.8) H/c	Revised
4	Die Category	Drg. No.	M. 10m 30	
5	Out Side Diameter	Drg. No.	705.9 mm, Step 00. 892 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		H/c Shop	Tapping H/c of H/c 10
12	Tapping PCD		645 mm	Rate 5.10
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 222.4 mm	Tapping Depth 222.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 4/8/25	
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			Counter Sink Ravi 3.8
2	External Relief Dia	4.3 mm	Outside (3-3)	Inner
3	External Relief Depth		4 mm	Will
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		4 8 25	
Inspected By (Sign) & Date			Ravi 4/8/25	

Satish 4/8/25

Reviewed by (Engineer-CNC)

Manager-QA