



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15739	45/50/8355
2	Machined By		V.T.L. n/c Shop	Dy. n/c lark 8310
3	Pallet Die No.		15417 (3.5)	
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	619.9 mm, Step 00, 611.9 mm, Step length 19.	
6	Inside Diameter	Drg. No.	520.14 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 Check by M20 Ball	Tapping Holes 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 18/8/25	
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 Hole Colused	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter 35
2	External Relief Dia	4.0 mm	Outside 23.35	Inner
3	External Relief Depth		12 mm	5 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		18 8 25	
Inspected By (Sign) & Date			Ravi 18/8/25	

10491

8355

8310

19.

18.4

Counter 35

23.35

5 mm

12 mm

Ravi

Lark Furnace

18 8 25

Ravi 18/8/25

Reviewed by (Engineer-CNC)

Manager-QA