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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.		15742	50/38
2	Machined By		V.T.L M/c Shop	Drilling No (Lead 95)
3	Pallet Die No.		15514 (3.8) mm	Rev 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	716 mm, Step od 693 mm	Step length. 20 mm
6	Inside Diameter	Drg. No.	600.14 mm	tapper. 12.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12x8x7 mm / 12x8x7	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		640 mm	of Holes: 12
13	Tapping Hole Diameter		M20, check by M.20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth. 20.5 mm	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/8/25

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

Counter - 60
Row. 33

1	Counter Sinking Depth & Finish	OK	outside				
2	External Relief Dia	4.3 mm	(3-3)	Inner			
3	External Relief Depth		16 mm	8 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			23	8	25	

Inspected By (Sign) & Date

Ravi 23/8/25

Reviewed by (Engineer-CNC)

Manager-QA