



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)

10580

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15876	50/50
2	Machined By		M/c Shop	Dry No. L.S.D-400
3	Pallet Die No.		15783	Rev. 02
4	Die Category	Drg. No.	JEW	
5	Out Side Diameter	Drg. No.	730 mm / Step OD 744 mm	Tapper. 10'
6	Inside Diameter	Drg. No.	630.14 mm	Step Length 233
7	Width of Pellet Die	Drg. No.	290.6 mm	Under Cut. 7mm
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 mm / 15.3 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	0.8mm Deep
11	Tapping Operator		M/c Shop	Both Side
12	Tapping PCD		685 mm	Tapping No
13	Tapping Hole Diameter		M.20 Check by M.20 Ball	of Holes. 16
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
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 3/9/25

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

1	Counter Sinking Depth & Finish	OK	outside						Row. 31
2	External Relief Dia	6.5 mm	(3-3)		Inner				
3	External Relief Depth		6 mm		0				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date				3	9	25		

Inspected By (Sign) & Date

Ravi 3/9/25

Reviewed by (Engineer-CNC)

Manager-QA