



Lark Engineering Company (India) Pvt. Ltd.

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

10594

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.			
2	Machined By		15821	31/55
3	Pallet Die No.		V.T.L M/c Shop	Dry No 1349
4	Die Category	Drg. No.	15479 (3.8)mm	Rev. Co.1)
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	710mm	Step 11 - 694mm, Tapper 12
7	Width of Pellet Die	Drg. No.	600.14mm	Step 11 length 20mm
8	Grooves as per Drawing	Drg. No.	222mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x7 / 12x8x7	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	
13	Tapping Hole Diameter		640mm	Tapping No. of Holes - 12
14	Tapping On Second Side	Half pitch of 1st side	M.20 Check by M.20 Bolt	Both Side
15	Tapping Hole Depth		OK	Tapping depth 20mm
16	Perpendicularity of Tapped Hole		Drill Depth 22.4mm	
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

1	As per programme no.		Ravi 5/9/25
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	OK	outside (3-3)	Inner 24mm	Counter-60°
2	External Relief Dia	4.3mm			Ravi 33
3	External Relief Depth		28mm		
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		5 9 25		

Inspected By (Sign) & Date

Ravi 5/9/25

Reviewed by (Engineer-CNC)

Manager-QA