



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)

10593

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15870	32/45/55
2	Machined By		V.T.L M/c Shop	Dry No. 407
3	Pallet Die No.		15480 (4.0) mm	Rev. (100)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	709.9 mm	Step OD - 6.92.8 mm Tapper
6	Inside Diameter	Drg. No.	600.14 mm	Step Length - 20
7	Width of Pellet Die	Drg. No.	222 mm	Under Cut
8	Grooves as per Drawing	Drg. No.	12x8x7 / 12x8x7	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		640 mm	Tapping No. 12
13	Tapping Hole Diameter		M.20 check by M.20 Ball of	Holes - 12
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
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 5/9/25

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
Part - 32

1	Counter Sinking Depth & Finish	OK	(outside)	Inner			
2	External Relief Dia		4.6 mm	all	Rough	= 23 mm	
3	External Relief Depth		5 mm	all	Rough	= 10 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			5	9	25	

Inspected By (Sign) & Date

Ravi 5/9/25

Reviewed by (Engineer-CNC)

Manager-QA