



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)

10599

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15794	34/47
2	Machined By		V.T.L M/c Shop	Dry No. 556
3	Pallet Die No.		14576 (2.8)mm	(Rev. 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	694 mm	Step 10 - 693 - Tapper 12
6	Inside Diameter	Drg. No.	600.14 mm	Stepth Length - 90
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	14x8x7 / 14x8x7	
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	
13	Tapping Hole Diameter		M.20 check by M.20 Bolt	Tapping No of Holes - 12
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth - 22.4 mm	Tapping depth - 20.5
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 - one Hole Close

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 600

Rev. 39

1	Counter Sinking Depth & Finish	OK	outside					
2	External Relief Dia	3.2 mm	(3-3)		Inner			
3	External Relief Depth		19 mm		13 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 05/9/25

Reviewed by (Engineer-CNC)

Manager-QA