



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.		15871	40/40 ✓
2	Machined By		V.T.L M/c Shop	Day No Rec-1506
3	Pallet Die No.		15093 (4.0) mm	Rev (00) ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm	Step OD - 492.88 Tapper - 13
6	Inside Diameter	Drg. No.	420.14 mm	Step leng = 18 mm
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 / 12x8x3	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No of Holes - 8
12	Tapping PCD		454 mm	Both Side
13	Tapping Hole Diameter		M.20 check by M.20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 18.8 mm	Tapping depth - 16.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 6/9/25

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

1	Counter Sinking Depth & Finish	OK	outside	Inner	Counter-60
2	External Relief Dia	4.5 mm	(2-2)	0	Row-20
3	External Relief Depth	4 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		6	9	25

Inspected By (Sign) & Date

Ravi - 6-9-25

Reviewed by (Engineer-CNC)

Manager-QA