



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.		15863	36/50/65
2	Machined By		V.T.L M/c Shop	Dry No-217
3	Pallet Die No.		16298 (4.0) mm	Rev (00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790 mm	Step 00-792 mm
6	Inside Diameter	Drg. No.	660.14 mm	Step 100-24.5
7	Width of Pellet Die	Drg. No.	324 mm	Under Cut-1 mm
8	Grooves as per Drawing	Drg. No.	21.5 X 8 X 8 / 21.5 X 8 X 8 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		725 mm	of Holes-12
13	Tapping Hole Diameter		M.20 Check by M.20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 31.4 mm	Tapping - 28.7 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 6/9/25	2 Slot - 8
1	As per programme no.			32.1 mm width
2	Gun Drilling Work Completed On			= 8 mm deep
3	Hole Finish In Gun Drilling	Marked	OK	Both Side
4	Defective Holes (If Any)		No 1 hole close to	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter-68
2	External Relief Dia		φ 4.5 mm all Rows = 29 mm	Row 43
3	External Relief Depth		φ 5 mm all Rows = 15 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	

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Reviewed by (Engineer-CNC)

Manager-QA