

Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

10627

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15997 ✓	40/48/55
3	Pallet Die No.		V.T.I M/C Shop	Dry No. 1st. 666
4	Die Category	Drg. No.	13491 (6.0)mm	(Rev 00)
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	710 mm	Step OD. 693mm Tapper 12°
7	Width of Pellet Die	Drg. No.	600.14 mm	Step Length 20
8	Grooves as per Drawing	Drg. No.	202 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x10x7.5 mm / 12x10x7.5mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/C Shop	Tapping No
13	Tapping Hole Diameter		640 mm	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	
16	Perpendicularity of Tapped Hole		Drill depth - 20.4 mm	Tapping depth - 18.4
17	Visual Inspection Before Gun Drilling		yes	
			OK	
Inspected By (Sign) & Date			Ravi 10/9/25	
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			Counter 60°
2	External Relief Dia	6.5mm / 4.0mm	6.5mm all Rows = 15mm	Row - 22
3	External Relief Depth		7.0 mm all Rows = 7mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark furnace	
6	Material Sent For Hardening On Date		10 9 25	
Inspected By (Sign) & Date			Ravi 10/9/25	

Reviewed by (Engineer-CNC)

Manager-QA