



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.		15475 ✓	40/50
2	Machined By		V.T.I M/c Shop	Dry No. Lec-13760
3	Pallet Die No.		15605	(Rev.00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm	Step OD-490.9 mm
6	Inside Diameter	Drg. No.	420.14 mm	Step Length 17.9
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 / 12x8x3 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		454 mm	of Holes-8
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 - 18.4 mm	Tapping depth-16.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		No	
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	OK	outside	Inner
2	External Relief Dia	(6.32) mm	(3-3)	(10 mm)
3	External Relief Depth	✓	16 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		10 9 25	
Inspected By (Sign) & Date			Ravi 10/9/25	

Satish 10/9/25

Counter. 60°
Row. 15

F. Reviewed by (Engineer-CNC)

Manager-QA