



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)

10645

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15897 ✓	41/50
3	Pallet Die No.		V.T.I. M/c Shop	Dry No. L.C.C. 10095
4	Die Category	Drg. No.	14428 (3.0) mm	Rev. 02
5	Out Side Diameter	Drg. No.	H-Jumbo	
6	Inside Diameter	Drg. No.	681.9 mm	Step OD = Tapper 12°
7	Width of Pellet Die	Drg. No.	580.14	Step length = 38 mm
8	Grooves as per Drawing	Drg. No.	266 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	28.5 x 6 x 12 mm / 28.5 x 6 x 12 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		630 mm	
13	Tapping Hole Diameter		M/G 2	
14	Tapping On Second Side	Half pitch of 1st side	Check by M/G Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 25.4 mm	Tapping depth = 23.4
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

Ravi 15/9/25

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

Counter 26

1	Counter Sinking Depth & Finish	OK	outside	Inner					Row 242
2	External Relief Dia	3.5 mm	(3-3)						
3	External Relief Depth		16 mm	10 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			15	9	25			

Inspected By (Sign) & Date

Ravi 15/9/25

Manager-QA

Reviewed by (Engineer-CNC)