



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.		15817	3C/55
2	Machined By		V.T.I M/c Shop	Dry No ~ 1.90.1315
3	Pallet Die No.		16335 (4.0)mm	Revised
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	813.9mm	Step OD 805.4mm Tapper 12
6	Inside Diameter	Drg. No.	675.14mm	Step Length 60.5
7	Width of Pellet Die	Drg. No.	409.9mm	Under cut 14.5mm
8	Grooves as per Drawing	Drg. No.	52x9x7mm / 52x9x7mm	
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 2
12	Tapping PCD		729.9mm	Both Side
13	Tapping Hole Diameter		M. 20 Check by 1/2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth ~ 40.4mm	Tapping depth ~ 37.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/9/25

1	As per programme no.			2 SI-L
2	Gun Drilling Work Completed On			30 mm width
3	Hole Finish In Gun Drilling	Marked	OK	40 mm Rack
4	Defective Holes (If Any)		No - 2 Hole. Closed	Both Side

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK	outside	Inner	Counter 26
2	External Relief Dia	4.5mm	(3-3)		Row 51
3	External Relief Depth		21mm	19mm	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark furnace		
6	Material Sent For Hardening On Date		18 9 25		

Inspected By (Sign) & Date

Ravi 17/9/25

Reviewed by (Engineer-CNC)

Manager-QA