



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15995	30/50
2	Machined By		V.T.L M/c Shop	Dry No. 1580998
3	Pallet Die No.		15138 (3.5) mm	Revised
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	619.9 mm	Step 00. Tapper = 12°
6	Inside Diameter	Drg. No.	520.14 mm	Step length = 18.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
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 = 12
12	Tapping PCD		565 mm	Both Side
13	Tapping Hole Diameter		M. 2.20 = Check by 420 B. 14	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.5 mm	Tapping depth = 86
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi	18/9/25
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							Counter 6
2	External Relief Dia	4.0 mm	Outside (2-3)		Inner				Row 2 35
3	External Relief Depth		23 mm		20 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				18	9	25		
Inspected By (Sign) & Date					Ravi		17/9/25		

Inspected By (Sign) & Date

Reviewed by (Engineer-CNC)

Manager-QA