



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)

10670

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15981	37/40
2	Machined By		V.T.L M/c Shop	Dry No = 120 = 93
3	Pallet Die No.		13959 (3.5) 44	Rev. 201
4	Die Category	Drg. No.	380	
5	Out Side Diameter	Drg. No.	500 44	Step 00 = 490.9 44
6	Inside Diameter	Drg. No.	420.14 44	Step length 16.5
7	Width of Pellet Die	Drg. No.	173 44	
8	Grooves as per Drawing	Drg. No.	10 x 8.5 x 5 44 / 10 x 8.5 x 5 44	
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 = 8
12	Tapping PCD		455 44	Both Side
13	Tapping Hole Diameter		13/4" 2 Check by 13/4" Bo	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.5 44	Tapping depth = 18.5
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	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 = 60°

1	Counter Sinking Depth & Finish	OK							Row = 28
2	External Relief Dia	4.0 44	Outside 82.25		Inner				
3	External Relief Depth		7 44		3 44				
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