



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10686

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.		15915	44/50
2	Machined By		V.T.I. M/c Shop	Dry No. 13d. 325
3	Pallet Die No.		15889 (4.0)mm	(Rev. 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9mm	Step OD = 499.9mm
6	Inside Diameter	Drg. No.	420.14mm	Tapper, 10°
7	Width of Pellet Die	Drg. No.	158mm	Step length. 18mm
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No. of Hole 28
12	Tapping PCD		455mm	Both Side
13	Tapping Hole Diameter		M202 C. back by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.4mm	Tapping depth = 16.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 19/9/25

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			Counter-60
2	External Relief Dia	4.5mm	(2-2)	(6mm)			Row 20
3	External Relief Depth		14mm				
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date			19	9	25	

Inspected By (Sign) & Date

Ravi 19-9-25

Reviewed by (Engineer-CNC)

Manager-QA