



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)

10724

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16017	45/50
2	Machined By		V.T.I. M/c Shop	Dray No 2 L-20, 9980
3	Pallet Die No.		15140 (5.0) mm	Rev 2.00
4	Die Category	Drg. No.	Part 29 side	
5	Out Side Diameter	Drg. No.	319.9 mm Step OD 2	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.	13-8 x 5 mm / 13-8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		565 mm	of Hole 1212
13	Tapping Hole Diameter		M202 Check by M202	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.5 mm	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/9/25

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 - 1 Hole Closed

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

Counter 26

1	Counter Sinking Depth & Finish	OK								Row 2 = 26
2	External Relief Dia	5.5 mm	20 Bole (2-3)		Inner					
3	External Relief Depth		10 mm		5 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				23	9	25			

Inspected By (Sign) & Date

Ravi 23/9/25

Saty 23/9/25

Reviewed by (Engineer-CNC)

Manager-QA