

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)

10718

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15988 ✓	40/40 ✓
3	Pallet Die No.		V.T.I. M/c Shop	Dry No 21.8.2-1506
4	Die Category	Drg. No.	15662 (4.0) ✓	Rev 2.00 ✓
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 mm, Step OD = 498.8 mm	
7	Width of Pellet Die	Drg. No.	420.14 mm	Tapped, 12°
8	Grooves as per Drawing	Drg. No.	158 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 mm 12 x 8 x 3 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		454 mm ✓	of Hole = 8
13	Tapping Hole Diameter		M20, Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.4 mm	Tapping depth = 16.5
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

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

Counter 2.00

1	Counter Sinking Depth & Finish	OK						Row 2.25
2	External Relief Dia	4.5 mm	20 Side 2.25		Inner			
3	External Relief Depth		4 mm		Will			
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		

Inspected By (Sign) & Date

Ravi 23/9/25

Reviewed by (Engineer-CNC)

Manager-QA