

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)

10730

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16089	39/50
2	Machined By		V.T.I. M/c Shop	Dry No 2-18.0.872
3	Pallet Die No.		15710 (3.5) mm	Row 2
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	620.2 mm	Step OD - 622.4 mm
6	Inside Diameter	Drg. No.	520.14 mm	Tapper 12°
7	Width of Pellet Die	Drg. No.	222 mm	Step length 20 mm
8	Grooves as per Drawing	Drg. No.	11x10x5 mm / 11x10x5 mm	Under cut 1.15 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 Holes 21
13	Tapping Hole Diameter		120.2 Check by 120 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 22.4 mm	Tapping depth 20.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/9/25

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 2-60

1	Counter Sinking Depth & Finish	OK								Row 2-35
2	External Relief Dia	4.0 mm	Outside 3-35		Inner					
3	External Relief Depth		18 mm		11 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				24	9	25			

Inspected By (Sign) & Date

Ravi 24/9/25

Satya 24/9/25

Reviewed by (Engineer-CNC)

Manager-QA