



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15575	75/75
2	Machined By		V.T.L M/c Shop	Day No 2 i.e. 2291
3	Pallet Die No.		16451 (8.0) m	Rev-60
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1061 m	Step OD = 1041 m Tapper. 4
6	Inside Diameter	Drg. No.	911.12 m (C Bm Tapper. 0.3 m)	Step length 29
7	Width of Pellet Die	Drg. No.	388 m	
8	Grooves as per Drawing	Drg. No.	33x10x10 m	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	1 m Deep Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		944.9 m	of Holes 216
13	Tapping Hole Diameter		H24, Check by H24 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 40.5 m	Tapping depth = 38 m
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/9/25

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						Counter 260
2	External Relief Dia	9.0 m	Outside (3-3)		Inner			Row = 30
3	External Relief Depth		8 m		N:11			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			28	9	25		

Inspected By (Sign) & Date

Ravi 28-9-25

Reviewed by (Engineer-CNC)

Manager-QA