



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.		16056	32/41
2	Machined By		V.T.I M/c Shop	Dry No-1355
3	Pallet Die No.		14378 (3.0)mm	(Rev 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	682 mm Step 2D	703 mm Tapped 4"
6	Inside Diameter	Drg. No.	600 mm	Step length 29.5
7	Width of Pellet Die	Drg. No.	250 mm	Undercut 10.5 mm
8	Grooves as per Drawing	Drg. No.	24X5X9 mm / 24X5X9 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		655 mm	of Hole 8-19
13	Tapping Hole Diameter		M.16 check by M.16 Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 24.4 mm	Tapping depth = 22.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 26/9/25	
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		Side 1st 2nd	Counter-60
2	External Relief Dia	(3.3 mm)	(9 mm)	Rev 2-41
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		26 9 25	
Inspected By (Sign) & Date			Ravi 26-9-25	

Reviewed by (Engineer-CNC)

Manager-QA