



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10793

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.		15994	42/42
2	Machined By		V.T.I. H/c Shop	Dry No. LSD-1112
3	Pallet Die No.		16055 (3.5)mm	(Rev 00)
4	Die Category	Drg. No.	SCW	
5	Out Side Diameter	Drg. No.	504mm	Step OD = 490.9mm
6	Inside Diameter	Drg. No.	420.14mm	Step length = 12mm
7	Width of Pellet Die	Drg. No.	182mm	
8	Grooves as per Drawing	Drg. No.	10x10x5mm 10x10x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No
12	Tapping PCD		455mm	of Holes = 8
13	Tapping Hole Diameter		0.21" = Check by 0.21" Ball	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth	Tapping depth
16	Perpendicularity of Tapped Hole		yes	17.4.
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 01/10/25	
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 - 2 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish		outside	Counter 60
2	External Relief Dia	4.0mm	(2-2)	Row 27
3	External Relief Depth		(4mm)	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		01 10 25	
Inspected By (Sign) & Date			Ravi 01/10/25	

01/10/25

Reviewed by (Engineer-CNC)

Manager-QA