



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.		15514	80/80
2	Machined By		V.T.L M/c Shop	Dry No = 1.5.2.1379
3	Pallet Die No.		16310 (3.5) mm	Revised
4	Die Category	Drg. No.	M7 & 10 (A1)	
5	Out Side Diameter	Drg. No.	759.9 mm	Step oD = 760.9 mm
6	Inside Diameter	Drg. No.	600.14 mm	Tapper = 12°
7	Width of Pellet Die	Drg. No.	265.6 mm	Step length 28.3
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 7 mm / 15.3 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	0.8 mm Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		640 mm	of Holes = 16
13	Tapping Hole Diameter		M2 = Check by M2 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 mm	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 03/10/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			Discussed with
3	Hole Finish In Gun Drilling	Marked	OK	Ming Sir
4	Defective Holes (If Any)		No - 25 Hole Coloured	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter = 60
2	External Relief Dia		No = Relief	Row = 42
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Shri Keshan Lark Furnace	
6	Material Sent For Hardening On Date		03 10 25	
Inspected By (Sign) & Date			Ravi 01/10/25	

Reviewed by (Engineer-CNC)

Manager-QA