



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16076	38/50
2	Machined By		V.T.L H/c Shop	Dayla = 14.0.2015
3	Pallet Die No.		14587 (4.0) H/c	Renewal
4	Die Category	Drg. No.	M. Jombo	
5	Out Side Diameter	Drg. No.	700 H/c	Step OD = 692.9 H/c
6	Inside Diameter	Drg. No.	600.14 H/c	Tapping = 12"
7	Width of Pellet Die	Drg. No.	222 H/c	Step length = 2"
8	Grooves as per Drawing	Drg. No.	14 x 8 x 7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	14 x 8 x 7 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		640 H/c	Tapping No of Holes = 12
13	Tapping Hole Diameter		H20	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 22.4 H/c	Tapping depth = 20.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi	27/9/25
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 = 26
2	External Relief Dia	4.5 H/c	Outside (3-3)		Inner			Row = 31
3	External Relief Depth		1.6 H/c		12 H/c			
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark	Furnace			
6	Material Sent For Hardening On Date			27	9	25		

Inspected By (Sign) & Date

			Ravi	27/9/25
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Reviewed by (Engineer-CNC)

Manager-QA