

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.		16154 ✓	40/50
2	Machined By		V.T.I. H/c Shop	Dry No = 1-302419
3	Pallet Die No.		14581(5.0) ✓	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 mm	Step oD = 691.9 mm
6	Inside Diameter	Drg. No.	600.14 mm	Step length = 19.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 mm / 12.5 x 8 x 7 mm	
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		645 mm	of Holes = 12
13	Tapping Hole Diameter		M20 Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 22.4 mm	Tapping depth = 20.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 29/9/25	
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 20
2	External Relief Dia	5.5 mm	208.10 (2-3)	Row = 27
3	External Relief Depth		15 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		29 9 25	
Inspected By (Sign) & Date			Ravi 29/9/25	

Reviewed by (Engineer-CNC)

Manager-QA