



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.		15592	40/55✓
2	Machined By		V.T.L M/c Shop	Dry No 21.8.0.1893
3	Pallet Die No.		10739(6.0)✓	See 1 co
4	Die Category	Drg. No.	417410	
5	Out Side Diameter	Drg. No.	710mm	Step OD = 703mm Tapped 228
6	Inside Diameter	Drg. No.	600.14mm	Step length 24.3
7	Width of Pellet Die	Drg. No.	265.6mm	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 7mm / 15.3 x 8 x 7mm	Race Side Step
9	Fitting Sizes on CNC Plate	Drg. No.	OK	0.8mm Deep
10	Drilling Area Surface Smoothness		OK	Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		640mm	of Holes = 16
13	Tapping Hole Diameter		M20 Check by 420 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4mm	Tapping depth = 18.4
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 60°
2	External Relief Dia	6.5mm	Outside (3-3)	Inner
3	External Relief Depth		22mm	15mm
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