



Lark Engineering Company (India) Pvt. Ltd.

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

10787

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.			
2	Machined By		16152 ✓	50/50
3	Pallet Die No.		V.T.L H/c Shop	Dry No - 1.20.1370
4	Die Category	Drg. No.	16023 (B.O.)	Reverse
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	520 mm	Step 0 D. 490.9 mm
7	Width of Pellet Die	Drg. No.	420.14 mm	Step length 17.5
8	Grooves as per Drawing	Drg. No.	158 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 mm	12 x 8 x 3 mm
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping No
13	Tapping Hole Diameter		454 mm	of Holes = 8
14	Tapping On Second Side	Half pitch of 1st side	H20. Check by H20 Bolt	Both side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 18.4 mm	Tapping depth = 16.4
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi	01/10/25
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		OK	
			No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK							Counter 360°
2	External Relief Dia	8.3 mm	22.25		Inner				Row 212
3	External Relief Depth		4 mm		Nil				
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		
					Ravi				
					01/10/25				

Inspected By (Sign) & Date

Satyam
11/10/25

Reviewed by (Engineer-CNC)

Manager-QA