



Lark Engineering Company (India) Pvt. Ltd.

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

10802

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		15751	39/50
3	Pallet Die No.		V.T.I. M/c Shop	Dry No. 1.20.998
4	Die Category	Drg. No.	15421 (4.0) H	Rev. 00
5	Out Side Diameter	Drg. No.	2nd side	
6	Inside Diameter	Drg. No.	619.9 H	Step 02
7	Width of Pellet Die	Drg. No.	520.14 H	Tapping 12"
8	Grooves as per Drawing	Drg. No.	222 H	Step length 18.5
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	
13	Tapping Hole Diameter		565 H	Tapping No. of Holes 212
14	Tapping On Second Side	Half pitch of 1st side	H202 Check by H2 B-1	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth 20.4 H	Tapping depth 18.5
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 03/10/25

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	4.5 H	OK Side (3-3)		Inner			Row 2 31
3	External Relief Depth		15 H		11 H			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			03	10	25		

Inspected By (Sign) & Date

Ravi 03/10/25

Reviewed by (Engineer-CNC)

Manager-QA