



Lark Engineering Company (India) Pvt. Ltd.

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

10798

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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		16115	37/40
3	Pallet Die No.		V.T.I M/c Shop	Dry No 2 Locks 2.15
4	Die Category	Drg. No.	15289 (3.5) mm	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 mm	Step OD = 490.9 mm
7	Width of Pellet Die	Drg. No.	420.14 mm	Step length = 12.5
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		M/c Shop	Tapping No
13	Tapping Hole Diameter		454 mm	of Holes = 8
14	Tapping On Second Side	Half pitch of 1st side	H2 = Check by H2 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	
Inspected By (Sign) & Date				
1	As per programme no.		Ravi	03/10/25
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		OK	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker			No	
1	Counter Sinking Depth & Finish			Counter = 60
2	External Relief Dia	OK	0.08 mm (2-2)	Rows = 22
3	External Relief Depth	4.0 mm	7 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		03 10 25	
Inspected By (Sign) & Date			Ravi	03/10/25

Reviewed by (Engineer-CNC)

Manager-QA