



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)

10861

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		13215	40/40 895
3	Pallet Die No.		M.T.I. M/c Shop	Drilling No. = 1022910
4	Die Category	Drg. No.	15676(4.0)mm	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	499.9mm	Step OD = 490.9mm
7	Width of Pellet Die	Drg. No.	420.14mm	Step length = 17.5
8	Grooves as per Drawing	Drg. No.	152mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm 12x8x3mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No.
12	Tapping PCD		454mm	of Hole = 8
13	Tapping Hole Diameter		420mm	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.4mm	Tapping depth = 16.4mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/10/25

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

Counter = 80
Row = 20

1	Counter Sinking Depth & Finish	OK	outside	inner			
2	External Relief Dia	4.5mm	(2.2)				
3	External Relief Depth		4mm	Mill			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark	furnace		
6	Material Sent For Hardening On Date			13	10	25	

Inspected By (Sign) & Date

Ravi 13/10/25

Reviewed by (Engineer-CNC)

Manager-QA