



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.		16113	4-160
2	Machined By		V. T. C. n/c Shop	Dy. No. 12.2.1343
3	Pallet Die No.		15946(4.0)M4	Rev. 2.00
4	Die Category	Drg. No.	Trumbo	
5	Out Side Diameter	Drg. No.	780mm Step 02. 798mm	Tapping 4°
6	Inside Diameter	Drg. No.	660.14mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	323.9mm	120mm cut. 9mm
8	Grooves as per Drawing	Drg. No.	21.5x8x7mm / 21.5x8x7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping 4°
12	Tapping PCD		725mm	of holes. 12
13	Tapping Hole Diameter		M20 x 2.0mm by M20 Bolt	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 30.4mm	Tapping Depth 28.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 16/10/25	P. 31.1
1	As per programme no.			32.1mm width
2	Gun Drilling Work Completed On			8mm Deep
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		1 Hole Closed	
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	4.5mm	Outside 3-3	Row 2 42
3	External Relief Depth		24mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		16 10 25	
Inspected By (Sign) & Date			Ravi 16/10/25	

10897

Satish 16/10/25

Reviewed by (Engineer-CNC)

Manager-QA