



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.		16118 ✓	35/45 ✓
2	Machined By		V. T. L. MLC Shop	Drg. No. 1.2.6.14949
3	Pallet Die No.		15880(4.5) ✓	Rev. No.
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510mm Step 02. 490.9mm -	
6	Inside Diameter	Drg. No.	420.14mm -	Step length 12.5
7	Width of Pellet Die	Drg. No.	158mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MLC Shop	
12	Tapping PCD		454mm ✓	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.6mm Tapping Depth 18.4	
16	Perpendicularity of Tapped Hole		Spec.	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rev: 16/10/25	
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 - 30
2	External Relief Dia	50mm	Outside 22-23	Inner 10mm
3	External Relief Depth		15mm	
4	Inspection Done Before Hardening By (Name)		Rev:	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		16 10 25	
Inspected By (Sign) & Date			Rev: 16/10/25	

Satya
16/10/25

Reviewed by (Engineer-CNC)

Manager-QA