



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)

10517

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15761	40/50
2	Machined By		V.T.L M/C Shop	Dry No. Lec. 1480
3	Pallet Die No.		15976 (4.0) mm	(Rev 0.3)
4	Die Category	Drg. No.	M.F.G.W.	
5	Out Side Diameter	Drg. No.	701 mm Step o.D. 703 mm	Step length 174
6	Inside Diameter	Drg. No.	600.14 mm	Under Cut 1 mm
7	Width of Pellet Die	Drg. No.	265.6	2° Taper 14°
8	Grooves as per Drawing	Drg. No.	15.3x8x7 / 15.3x8x7	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No
10	Drilling Area Surface Smoothness		OK	of Holes - 16
11	Tapping Operator		M/C Shop	Both side
12	Tapping PCD		640 mm	Face Grooves (0.8) mm
13	Tapping Hole Diameter		M.20 check by M.20 Ball	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.6 mm	Tapping 18.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/8/25

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 - 60

1	Counter Sinking Depth & Finish	OK	outside	Inner				Row - 39
2	External Relief Dia	4.5	(3-3)	14 mm	10 mm			
3	External Relief Depth							
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date			23	8	25		

Inspected By (Sign) & Date

Ravi 23/8/25

Reviewed by (Engineer-CNC)

Manager-QA