



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.		13822	36/50
2	Machined By		N.T.L. H/c Shop	Drg. No. 1302947
3	Pallet Die No.		13183(G-0)MM	Rev 01
4	Die Category	Dr. No.	SE 10	
5	Out Side Diameter	Dr. No.	520MM, Step 00. 499MM	Tapper: 12"
6	Inside Diameter	Dr. No.	420.12MM	Step length 14MM
7	Width of Pellet Die	Dr. No.	182MM	
8	Grooves as per Drawing	Dr. No.	1078x3MM / 1078x3MM	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H- of Hole B Both Side
12	Tapping PCD		454MM	
13	Tapping Hole Diameter		Ø3/4", Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.2MM Tapping Depth: 16.5MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/1/25

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

Count on 60°

1	Counter Sinking Depth & Finish	ok								Rev 219
2	External Relief Dia	6.5MM	Outside (2.2)		Inner					
3	External Relief Depth		20MM		14MM					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Roxace					
6	Material Sent For Hardening On Date				6	1	25			

Inspected By (Sign) & Date

Ravi 6/1/25

Satya 7/1/13

Reviewed by (Engineer-CNC)

Manager-QA