



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)

9594

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14597	30/51
2	Machined By		V. T. L. N/A Shop	Qty 180
3	Pallet Die No.		14567 (-3.0) mm	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	802 mm / Step 002 802.9 mm	Tapping 24
6	Inside Diameter	Drg. No.	700.14 mm	Step length 38 mm
7	Width of Pellet Die	Drg. No.	324 mm	Under cut 10.5 mm
8	Grooves as per Drawing	Drg. No.	30x8x8.5 mm / 30x8x8.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping No. of holes 12
12	Tapping PCD		760 mm	Both Side
13	Tapping Hole Diameter		M22 = Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 36.3 mm	Tapping Depth 34.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 11/4/25

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60
Corr 53

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5 mm	Outside (3-3)		Inner		
3	External Relief Depth		24 mm		21 mm		
4	Inspection Done Before Hardening By (Name)				Raw		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date		11	4	25		

Inspected By (Sign) & Date

Raw: 11/4/25

Reviewed by (Engineer-CNC)

Manager-QA