



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.		14728	50/60
2	Machined By		N.T.L. H/c Shop	Drill 18.0.413
3	Pallet Die No.		14154 (8.0) mm	Revised
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	72 mm, Step 00 = 69 mm	Tapping 12
6	Inside Diameter	Drg. No.	600.12 mm	Step length 20 mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	14787 7 mm / 14787 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/c. Shop	Tapping 12
12	Tapping PCD		640 mm	of holes 12
13	Tapping Hole Diameter		H2 = Check by H2-Bolt	V. Boku Sdk
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.4 mm	Tapping Depth 20.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 22/4/25	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter 18
2	External Relief Dia	2.5 mm	23.3	Inner
3	External Relief Depth		15 mm	10 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark for no. 2	
6	Material Sent For Hardening On Date		22 4 25	
Inspected By (Sign) & Date			Ravi 22/4/25	

Reviewed by (Engineer-CNC)

Manager-QA