



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Hold

9824

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.		14757	34/40
2	Machined By		V.T.L. M/c Shop	Drilling Holes 1-2-3-4-5-6-7-8
3	Pallet Die No.		14983 (3.0) mm	Rev 2.00
4	Die Category	Drg. No.	SEP	
5	Out Side Diameter	Drg. No.	500mm Step 00. 490.7mm	Step length 210.5
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	173 mm	
8	Grooves as per Drawing	Drg. No.	12x10x5 mm / 12x10x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		455 mm	
13	Tapping Hole Diameter		03/4" = Check by 03/4" B.I.	Tapping Holes of 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 mm	Tapping Depth = 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	Approved By
Inspected By (Sign) & Date			Rev: 5/5/25	As per discussion with Sales team & Management.
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 Sink Rev = 27
2	External Relief Dia	3.3 mm	Outside 2.2	Inner
3	External Relief Depth		12 mm	6 mm
4	Inspection Done Before Hardening By (Name)		Rev:	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		5	5
Inspected By (Sign) & Date			Rev: 5/5/25	

Reviewed by (Engineer-CNC)

Manager-QA