



Lark Engineering Company (India) Pvt. Ltd.

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

9899

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.			
2	Machined By		14973 ✓	40/50 ✓
3	Pallet Die No.		V-7.6 n/c Shop	Dy 4.1.2.0.148-5
4	Die Category	Drg. No.	14605(4.0) ✓	Rev. 03
5	Out Side Diameter	Drg. No.	14780	
6	Inside Diameter	Drg. No.	701 mm Step 00. Tapper 12°	
7	Width of Pellet Die	Drg. No.	600.14 mm	Step length 17.4 mm
8	Grooves as per Drawing	Drg. No.	265.6 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	15.3 x 8 x 7 mm / 15.3 x 8 x 7 mm	Face Side Step
10	Drilling Area Surface Smoothness		ok	Top side Deep
11	Tapping Operator		n/c Shop	Bottom Side
12	Tapping PCD		6.40 mm	Tapping Holes 16
13	Tapping Hole Diameter		120 = Check by H2 B.1	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 2.8 mm	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 19/5/25

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 G
2	External Relief Dia	4.5 mm	23.3 Side		Inner			Raw: 39
3	External Relief Depth		14 mm		10 mm			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		19	5	25			

Inspected By (Sign) & Date

Raw: 19/5/25

Saty 19/5/25
Reviewed by (Engineer-CNC)

Manager-QA