



Lark Engineering Company (India) Pvt. Ltd.

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

10018

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.		15065	40/45/55
2	Machined By		V.T.L. H/C Shop	Dy H. 12.07.13
3	Pallet Die No.		14241(8.0) H/C	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	710 H/C	Step length 19.5
6	Inside Diameter	Drg. No.	600.14 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	36x10x7 H/C / 36x10x7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		645 H/C	Tapping H. of Holes - 12
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 3/8/25

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

Counter 280°

1	Counter Sinking Depth & Finish	OK								Row 13
2	External Relief Dia	8.5 H/C / 9.0 H/C	8.5 H/C	All Rows	2 15 H/C					
3	External Relief Depth		9.0 H/C	All Rows	2 10 H/C					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date

Raw: 3/8/25

Reviewed by (Engineer-CNC)

Manager-QA