



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.		15072	55/66
2	Machined By		N.T.L. NLC Shop	60/66
3	Pallet Die No.		15157 (10.0) mm	Qty 12.9.32
4	Die Category	Drg. No.	N. Jombo	Rev. 08
5	Out Side Diameter	Drg. No.	680.1 mm	Step 02 - 693 mm
6	Inside Diameter	Drg. No.	546.12 mm	Step length 3 mm
7	Width of Pellet Die	Drg. No.	195 mm	Order center 2.8 mm
8	Grooves as per Drawing	Drg. No.	32.789.1 mm	(4x8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep
11	Tapping Operator		NLC Shop	Both Side
12	Tapping PCD		619 mm	Tapping No
13	Tapping Hole Diameter		N16 - Check by N16 Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 mm	Tapping Depth 31.6 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Savi 6/6/25

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 60
2	External Relief Dia	11.0 mm	Ist Pad		Ind Pad			Rev 8
3	External Relief Depth		11 mm		6 mm			
4	Inspection Done Before Hardening By (Name)							Savi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		6	6	25			

Inspected By (Sign) & Date

Savi 6/6/25

Reviewed by (Engineer-CNC)

Manager-QA