



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.		15189	45/60
2	Machined By		V. T. L. H/c Shop	Drg. H. 1.8.0.1343
3	Pallet Die No.		15637 (R.O.)	Reason
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm Step 002 798mm	Tappet 40
6	Inside Diameter	Drg. No.	660.14mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	324mm	Under cut 9mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 7mm / 21.5 x 8 x 7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H.
12	Tapping PCD		725mm	of Holes 12
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 30.4mm	Tapping Depth 28.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/6/25

1	As per programme no.				2 31.1
2	Gun Drilling Work Completed On				32.1mm wide
3	Hole Finish In Gun Drilling	Marked	ok		8mm Deep
4	Defective Holes (If Any)		No		Both Side

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	8.5mm	23.35		Inner			27
3	External Relief Depth		23mm		15mm			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		14	6	25			

Inspected By (Sign) & Date

Ravi 14/6/25

Reviewed by (Engineer-CNC)

Manager-QA