



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.		15184 / 15201	36/51
2	Machined By		V. T. L. n/c. Shop	Drg. No. 15.0.1338
3	Pallet Die No.		15471 (3-0) n/c	Rev. no.
4	Die Category	Drg. No.	10000	
5	Out Side Diameter	Drg. No.	73.2 mm / Step OD = 74.3 mm	Tapper. 4°
6	Inside Diameter	Drg. No.	63.014 mm	Step length = 7.5
7	Width of Pellet Die	Drg. No.	27.5 mm	Under cut = 5.5 mm
8	Grooves as per Drawing	Drg. No.	22-8-7 mm / 22-8-7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping H. of holes = 12
12	Tapping PCD		68.5 mm	Both Side
13	Tapping Hole Diameter		M22 - Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 28.4 mm	Tapping Depth = 28.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 16/6/25

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. 6°
2	External Relief Dia	3.5 mm	Outside 3.35		Inner				
3	External Relief Depth		21 mm		15 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		16	6	25				

Inspected By (Sign) & Date

Ravi 16/6/25

Reviewed by (Engineer-CNC)

Manager-QA