



Lark Engineering Company (India) Pvt. Ltd.

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

10163

Form No.

CNC/QA/FM/02

Rev. No.

01

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15251	45/50
2	Machined By		V. T. L. H/c Shop	Dry H. L. 1.40.190
3	Pallet Die No.		14553(4.0) H/c	Rev. 01
4	Die Category	Drg. No.	70 mm	
5	Out Side Diameter	Drg. No.	76 mm Step no. 79 mm	Step length 27
6	Inside Diameter	Drg. No.	66.14 mm	Under cut. 1.40
7	Width of Pellet Die	Drg. No.	324 mm	
8	Grooves as per Drawing	Drg. No.	21 x 8 x 10 mm / 21 x 8 x 10 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H. of Holes. 12
12	Tapping PCD		725 mm	Both Side
13	Tapping Hole Diameter		H20. Check by H20. B-1	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 27.4 mm	Tapping Depth 25
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 28/6/25	28.1
1	As per programme no.			32.1 mm width
2	Gun Drilling Work Completed On			9 mm Depth
3	Hole Finish In Gun Drilling	Marked	OK	Both Side
4	Defective Holes (If Any)		No - 1 Hole Closed	
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	4.5 mm	90 Side 3-35	Rev. 48
3	External Relief Depth		13 mm	5 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Engineering	
6	Material Sent For Hardening On Date		28/6/25	
Inspected By (Sign) & Date			Ravi 28/6/25	

Reviewed by (Engineer-CNC)

Manager-QA