



Lark Engineering Company (India) Pvt. Ltd.

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

10222

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.			
2	Machined By		1542	38/40
3	Pallet Die No.		M. T. L. Shop	By the last 315
4	Die Category	Drg. No.	14670 (3.5) H	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	490.8mm, Step on 491mm	Step length 17.5
7	Width of Pellet Die	Drg. No.	420.14mm / 421.4mm (B)	
8	Grooves as per Drawing	Drg. No.	158mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12-8-2 mm / 12-8-3mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/L Shop	
13	Tapping Hole Diameter		454mm	
14	Tapping On Second Side	Half pitch of 1st side	M20, Check by M20 Bolt	Tapping W. of holes @ Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 18.4mm	Tapping Depth 18.6
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

3/7/25

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	4.0mm	Outside 2.25	Inner				22
3	External Relief Depth		8mm	2mm				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		3	7	25			

Inspected By (Sign) & Date

3/7/25

Reviewed by (Engineer-CNC)

Manager-QA