



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)

10254

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15189	45/60
2	Machined By		N.T.L. n/a Shop	Dry hole 2.1.1843
3	Pallet Die No.		15941 (8.0) n/a	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm, Step 00. 798mm	Tappers 4"
6	Inside Diameter	Drg. No.	660.14mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	324mm	Order 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		n/a Shop	
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M20, Check by M20 Ball	Tapping of hole 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 280mm	Tapping Depth 280mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 12/7/25	
1	As per programme no.			2 Slot
2	Gun Drilling Work Completed On			32.1mm hole
3	Hole Finish In Gun Drilling	Marked	OK	8mm Depth Both Side
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 26mm
2	External Relief Dia	8.5mm	Outside 23-35	
3	External Relief Depth		23mm	Inner 18mm
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		12/7/25	
Inspected By (Sign) & Date			Sasi 12/7/25	

Reviewed by (Engineer-CNC)

Manager-QA