



Lark Engineering Company (India) Pvt. Ltd.

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

10252

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		15301	42/69
3	Pallet Die No.		V.T.L H/C Shop	38/43/69
4	Die Category	Drg. No.	14801 (G.O.)	Drg. No. 1801 893
5	Out Side Diameter	Drg. No.	Turner	Revised
6	Inside Diameter	Drg. No.	838 mm Step 0.0, 848 mm	Tapper 5
7	Width of Pellet Die	Drg. No.	698.14 mm (Box 2 700.14) mm	Step length 38.5 mm
8	Grooves as per Drawing	Drg. No.	240.4 mm	End of 1.9 mm
9	Fitting Sizes on CNC Plate	Drg. No.	29x10x9 mm / 29x10x9 mm	(G-8) mm
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/C Shop	
13	Tapping Hole Diameter		765 mm	
14	Tapping On Second Side	Half pitch of 1st side	H/C Check by H/C B-12	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 324 mm	Tapping Depth 30.5
17	Visual Inspection Before Gun Drilling		Yes	
Inspected By (Sign) & Date			Sai: 12/7/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		OK	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish			Counter = 30
2	External Relief Dia		1st Pad 2.5 mm / 7 mm	Row = 18
3	External Relief Depth		7 mm / 28 mm	6.5 mm All Rows 31 mm
4	Inspection Done Before Hardening By (Name)			7 mm All Rows 26 mm
5	Material Sent For Hardening By (Name)			
6	Material Sent For Hardening On Date		12/7/25	
Inspected By (Sign) & Date			Sai: 12/7/25	

Reviewed by (Engineer-CNC)

Manager-QA