



Lark Engineering Company (India) Pvt. Ltd.

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

10359

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.		15589	44/50
2	Machined By		V. T. L. n/c Shop	Dr. H. L. 0.450
3	Pallet Die No.		15476(4.0)	Rev. 02
4	Die Category	Drg. No.	7610	
5	Out Side Diameter	Drg. No.	730mm, Step 0.0, 743.8mm	Topper = 1
6	Inside Diameter	Drg. No.	630.14mm	Step length = 23.2
7	Width of Pellet Die	Drg. No.	290.6mm	Under cut = 7mm
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5mm / 15.3 x 8 x 5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side step
10	Drilling Area Surface Smoothness		ok	0.8mm Deep Both Side
11	Tapping Operator		n/c Shop	Tapping 40
12	Tapping PCD		685mm	of holes 16
13	Tapping Hole Diameter		M20. Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.5mm	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Raw: 25/7/25	
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	4.5mm	Outside (3-3)	Raw: 43
3	External Relief Depth	14mm	Inner 6mm	
4	Inspection Done Before Hardening By (Name)		Raw	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		25	7 25
Inspected By (Sign) & Date			Raw: 25/7/25	

Satya 25/7/25

Reviewed by (Engineer-CNC)

Manager-QA