



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15604	40/40
2	Machined By		V. T. L. H/c Shop	8/5
3	Pallet Die No.		15086 (4.5) H/c	10/5
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9 mm	Step 00: 490.9 mm
6	Inside Diameter	Drg. No.	480.14 mm	Step 6: 475.14 mm
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm / 12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20: Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 18.8 mm	Tapping Depth: 18.7 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Inspected By: 28/7/25

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							
2	External Relief Dia	5.0 mm	Outside 2.2		Inner				
3	External Relief Depth		5 mm		Nil				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		28	7	25				

Inspected By (Sign) & Date

Inspected By: 28/7/25

Satya 28/7/25

Reviewed by (Engineer-CNC)

Manager-QA