



Lark Engineering Company (India) Pvt. Ltd.

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

10407

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.		15605	44/50
2	Machined By		V. T. L. n/c Shop	Qty 12.0.150
3	Pallet Die No.		15712 (4.0) n/c	Rev: 02
4	Die Category	Drg. No.	J&N	
5	Out Side Diameter	Drg. No.	730mm	Step 00: 744mm
6	Inside Diameter	Drg. No.	630.14mm	Tabben: 10"
7	Width of Pellet Die	Drg. No.	290.6mm	Step Length: 93.7
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5mm / 15.3 x 8 x 5mm	Undercut: 7mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		885mm	
13	Tapping Hole Diameter		M20: Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.5mm	Tapping Depth: 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 11/8/25	
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		4.5mm	
3	External Relief Depth		14mm	
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Purchase	
6	Material Sent For Hardening On Date		1 8 25	
Inspected By (Sign) & Date			Sasi 11/8/25	

Reviewed by (Engineer-CNC)

Manager-QA