



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

10548

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.		15683	38/50
2	Machined By		N.T.L. H/c Shop	Drg. No. 18.0153
3	Pallet Die No.		16257 (G.O) H/c	Review
4	Die Category	Drg. No.	Senior 2 (A8.1)	
5	Out Side Diameter	Drg. No.	519.9 H/c	490.9 H/c
6	Inside Diameter	Drg. No.	420.14 H/c	Step length 16.5
7	Width of Pellet Die	Drg. No.	180 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 9 x 3 H/c / 12 x 9 x 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping N/c of 1 hole 8 Rod side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/c Shop	
12	Tapping PCD		03/4" 2 Check by 03/4" Ball	
13	Tapping Hole Diameter		04.54 H/c	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/8/25

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						Counter G
2	External Relief Dia	6.5 H/c	20.8 H/c	22.25	Inner			20.15
3	External Relief Depth		18 H/c		12 H/c			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				R.R			
6	Material Sent For Hardening On Date		29	8	25			

Inspected By (Sign) & Date

Ravi 29/8/25

Reviewed by (Engineer-CNC)

Manager-QA