



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.		15952	33/4
2	Machined By		V. T. L. n/c Shop	Drill 18.0156
3	Pallet Die No.		15661 (3.0) re	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm Step 02 Tapper 12	
6	Inside Diameter	Drg. No.	420.14 mm	Step length 18 mm
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm 12 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of holes 8
12	Tapping PCD		454 mm	Both Side
13	Tapping Hole Diameter		420 mm Check by 420 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 mm Tapping Depth 18 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 17/9/25	
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		Comden, Co
2	External Relief Dia	3.5 mm	80 Side Inner	Rev. 24
3	External Relief Depth		13 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Rurnace	
6	Material Sent For Hardening On Date		17 9 25	
Inspected By (Sign) & Date			Ravi 17/9/25	

Reviewed by (Engineer-CNC)

Manager-QA