



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.		18088	45/50
2	Machined By		V.T.L. H/c Shop	Dry No. 2 L.S.O. 370
3	Pallet Die No.		15899 (G.O.)	Rev. no
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5.20 mm	Step OD 2 490.9 mm
6	Inside Diameter	Drg. No.	4.20.14 mm	Step length 19.0 mm
7	Width of Pellet Die	Drg. No.	159.5 mm	17.5 mm
8	Grooves as per Drawing	Drg. No.	18.5 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		H/c Shop	Tapping No
12	Tapping PCD		454 mm	of Holes = 8
13	Tapping Hole Diameter		0.314" = Check by 0.314" Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.5 mm	Tapping depth = 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 23/9/25	
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		Counter = 60
2	External Relief Dia	6.5 mm	Outside (2-2)	Row = 15
3	External Relief Depth		11 mm	5 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		23 9 25	
Inspected By (Sign) & Date			Ravi 23-9-25	

Reviewed by (Engineer-CNC)

Manager-QA