



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.		16030	55/55
2	Machined By		U-T-L M/c Shop	Drg No LEC 14924
3	Pallet Die No.		11014 (4.02 mm)	
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	630 mm	Step OD 612 mm
6	Inside Diameter	Drg. No.	520 mm	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No of
10	Drilling Area Surface Smoothness		OK	Hole M
11	Tapping Operator		m/c Shop	Both side
12	Tapping PCD		56.5 mm	
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 20.5 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			mahesh 6/10/25	
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	4.5 mm	outer (3-3)	inner
3	External Relief Depth		5.5	0
4	Inspection Done Before Hardening By (Name)		mahesh	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		06	10 25
Inspected By (Sign) & Date			mahesh 6/10/25	

Reviewed by (Engineer-CNC)

Manager-QA