



Lark Engineering Company (India) Pvt. Ltd.

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

10825

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.		16173	88/50 ✓
2	Machined By		VTL M/c Shop	
3	Pallet Die No.		14585 (4.5)mm	223 No LSC 12501 (P01)
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	700 mm	Step OD 685.77mm
6	Inside Diameter	Drg. No.	600 mm	Step Length 20mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12x8x7 mm	Tapping No of Hole 12
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		640	
13	Tapping Hole Diameter		M 20 check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.5 Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Mahesh 8/10/25

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	outer (3.3)		inner		Row 31
3	External Relief Depth		16.5 mm		12.3 mm		
4	Inspection Done Before Hardening By (Name)		Mahesh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		8	10	25		

Inspected By (Sign) & Date

Mahesh 8/10/25

Reviewed by (Engineer-CNC)

Manager-QA