



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)

10852

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15701	B-166
2	Machined By		V.T.L. H/L Shop	Dr. H. L. 120.9
3	Pallet Die No.		16444(3.5)mm	Rev. 01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032 mm	Step 00.1033 mm - Tappers 2°
6	Inside Diameter	Drg. No.	900.14 mm	Step length 2.2 mm
7	Width of Pellet Die	Drg. No.	375 mm	Under cut 0.3 mm
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 8 x 13	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/L Shop	
12	Tapping PCD		970 mm	
13	Tapping Hole Diameter		M24	Check by M24 Bol
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 38.4 mm	Tapping Depth 38.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/10/25

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

Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0 mm	outside (4-4)		inner				
3	External Relief Depth		13 mm		6 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		10	10	25				

Inspected By (Sign) & Date

Ravi 10/10/25

Satish 10/10/25

Reviewed by (Engineer-CNC)

Manager-QA