



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.		16157	42/50
2	Machined By		V.T.I. M/c Shop	Dry No. 120.71
3	Pallet Die No.		15830(4.0) mm	Rev. 00
4	Die Category	Drg. No.	Ext. 24.10.10	
5	Out Side Diameter	Drg. No.	620 mm	Step OD: 682.4 mm
6	Inside Diameter	Drg. No.	520.14 mm	Tapper: 40
7	Width of Pellet Die	Drg. No.	222 mm	Step length: 17 mm
8	Grooves as per Drawing	Drg. No.	9x10x4 mm / 9x10x4 mm	Under cut: 1.2 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		565 mm	at Hole 212
13	Tapping Hole Diameter		M20	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.5 mm	Tapping depth = 18.4
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

1	Counter Sinking Depth & Finish	OK	outside	Inner	Counter: 60
2	External Relief Dia	4.5 mm	(3-3)		Row 2 = 32
3	External Relief Depth		12 mm	8 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				

Inspected By (Sign) & Date

Ravi 10/10/25

Reviewed by (Engineer-CNC)

Manager-QA