



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)

10878

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16241	17/66
2	Machined By		N. T. L. N/A Shop	Qty 11, 12.0. 39
3	Pallet Die No.		16468(6.0)	Rev 103
4	Die Category	Drg. No.	N. T. L. N/A Shop	
5	Out Side Diameter	Drg. No.	680.7 mm	Step 0.25 692.9 mm Taper 8°
6	Inside Diameter	Drg. No.	546.14 mm (Box = 548.4)	Step length = 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm	(4 x 2) mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 mm Deep
11	Tapping Operator		N/A Shop	Both Side
12	Tapping PCD		619 mm	Tapping Holes
13	Tapping Hole Diameter		M16	of holes = 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth = 33.4 mm	Tapping Depth = 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/10/25

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

Ground end 30

1	Counter Sinking Depth & Finish	OK						Row 12
2	External Relief Dia	7.5 mm		All Rows				
3	External Relief Depth			49 mm				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Porrace				
6	Material Sent For Hardening On Date		14	10	25			

Inspected By (Sign) & Date

Ravi 14/10/25

Reviewed by (Engineer-CNC)

Manager-QA