



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.		14884	30/40
2	Machined By		V. T. L. n/c Shop	8195
3	Pallet Die No.		14902 (3.0)	810
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm Step on. 490.9 mm	Step length 17.5
6	Inside Diameter	Drg. No.	42.14 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		142. Check by H20 Bolt	Tapping Holes 28
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 19 mm Tapping Depth 17 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/5/25

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 260

1	Counter Sinking Depth & Finish	OK						Rep. 24
2	External Relief Dia	3.5 mm	Outside 2.25	Inner				
3	External Relief Depth		13 mm	10 mm				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		24	5	25			

Inspected By (Sign) & Date

Ravi 24/5/25

Reviewed by (Engineer-CNC)

Manager-QA