



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.		15036	40/60
2	Machined By		V. T. L. H/c Shop	Qty No. 12.0584
3	Pallet Die No.		14752 (6.0) mm	Rev. 01
4	Die Category	Drg. No.	70460	
5	Out Side Diameter	Drg. No.	780 mm	Step on. 798 mm
6	Inside Diameter	Drg. No.	660.12 mm	Tappet. 4°
7	Width of Pellet Die	Drg. No.	324 mm	Step length. 25.5
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 mm	Load on cut 29 mm
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 10 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		725 mm	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 30.4 mm	Tapping Depth. 28.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/5/25

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 mm	Outside (3-3)		Inner				
3	External Relief Depth		26 mm		20 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		28	5	25				

Inspected By (Sign) & Date

Ravi 28/5/25

Reviewed by (Engineer-CNC)

Manager-QA