



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.		15101	40/60
2	Machined By		N. T. L. H/c Shop	Drg. No. 1.8.0.247
3	Pallet Die No.		14917 (8.0) mm	Rev. No.
4	Die Category	Drg. No.	N. Tumbo	
5	Out Side Diameter	Drg. No.	719.9 mm, Step 02. 692.8 mm	Tapping 18
6	Inside Diameter	Drg. No.	600.14 mm	Step length 4.2 mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 mm / 12x10x7.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of 1.8.0.12
12	Tapping PCD		640 mm	Base Side
13	Tapping Hole Diameter		M20, Check by H/c Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm, Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 5/6/25

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						Counter B.
2	External Relief Dia	8.5 mm	Outside 23.3		Inner 20 mm			Raw: 18
3	External Relief Depth		25 mm					
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		5	6	25			

Inspected By (Sign) & Date

Raw: 5/6/25

Reviewed by (Engineer-CNC)

Manager-QA