



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10733

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.		15989	40/55
2	Machined By		V.Til M/c Shop	Dry No. 1.3.0. 86
3	Pallet Die No.		15486 (4.0) mm	Row 30
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	709.9 mm	Step OD = 692.9 mm
6	Inside Diameter	Drg. No.	600.14 mm	Step length = 20 mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 mm / 12 x 10 x 8.5 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		640 mm	of Holes = 12
13	Tapping Hole Diameter		H202 Check by H20 Bull	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 mm	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/9/25

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 = 60
Row = 31

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5 mm	Outside 23-31	Inner			
3	External Relief Depth		19 mm	15 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			24	9	25	

Inspected By (Sign) & Date

Ravi 24-9-25

Reviewed by (Engineer-CNC)

Manager-QA