



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.		16157	42/50
2	Machined By		V.T.L. n/c Shop	Dy No. 18.0.71
3	Pallet Die No.		15829(4.0)44	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620mm, Step 00, 620.4mm	
6	Inside Diameter	Drg. No.	520.14mm	Tapber. 12"
7	Width of Pellet Die	Drg. No.	222mm	Step length. 17mm
8	Grooves as per Drawing	Drg. No.	9x10x4mm / 9x10x4mm	Order cut = 1.2mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping 4"
12	Tapping PCD		565mm	of holes = 12
13	Tapping Hole Diameter		420, Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.5mm	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi: 10/10/25	
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				
1	Counter Sinking Depth & Finish	ok		Counter. 32
2	External Relief Dia	4.5mm	Outside (3-3)	Inner
3	External Relief Depth		12mm	8mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		10	10 25
Inspected By (Sign) & Date			Ravi: 10/10/25	

Reviewed by (Engineer-CNC)

Manager-QA