



Lark Engineering Company (India) Pvt. Ltd.

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

10521

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.		15763	45/50
2	Machined By		V.T.L M/C SHOP	
3	Pallet Die No.		15425 (3.2)mm	Drig No 1SD.406 (Rev.00)
4	Die Category	Drg. No.	SSC-W	
5	Out Side Diameter	Drg. No.	62mm, Step OD 62.9mm	Tapper 12°
6	Inside Diameter	Drg. No.	52.14 mm	Step Length 18.5mm
7	Width of Pellet Die	Drg. No.	222 mm	Under Cut 1.2
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C SHOP	Tapping NO of Holes - 12
12	Tapping PCD		365 mm	Both Side
13	Tapping Hole Diameter		M.20 Check by M.20 Ball	
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 23/8/25

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	outside					Counter-60
2	External Relief Dia	3.8 mm	(3-3)		Taper			Draw-37
3	External Relief Depth		12mm		5mm			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			23	8	25		

Inspected By (Sign) & Date

Ravi 23/8/25

Reviewed by (Engineer-CNC)

Manager-QA