



Lark Engineering Company (India) Pvt. Ltd.

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

10519

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.		15781	42/50
2	Machined By		V.T.L. M/c Shop	Dry No. 1/150.276
3	Pallet Die No.		14782 (3.5) mm	(Rev. 01)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620 mm Step OD 623.5 mm	Tapper 12/13
6	Inside Diameter	Drg. No.	520.14 mm	Step Length 20 mm
7	Width of Pellet Die	Drg. No.	186 mm	Undercut 1.8 mm
8	Grooves as per Drawing	Drg. No.	13X8X3 mm / 13X8X3 mm	
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		565 mm	Both side
13	Tapping Hole Diameter		M.20 Check by H.20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.5 mm	Tapping 18.4 mm
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

Counter-60

1	Counter Sinking Depth & Finish	OK	outside	inner				Ravi 27
2	External Relief Dia	4.01	(3.3)	8 mm				
3	External Relief Depth		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			23	8	25		

Inspected By (Sign) & Date

Ravi 23/8/25

Reviewed by (Engineer-CNC)

Manager-QA