



Lark Engineering Company (India) Pvt. Ltd.

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

10518

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.		15785	55/55
2	Machined By		V.T.L M/c Shop	Dry No. 1.2014 927
3	Pallet Die No.		16026 (5.6) mm	Rev. 00
4	Die Category	Drg. No.	SSGW	
5	Out Side Diameter	Drg. No.	629.9 mm, Step OD 611.8	Step Length 19.5 mm
6	Inside Diameter	Drg. No.	520.14 mm	
7	Width of Pellet Die	Drg. No.	992 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 / 13x8x5	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No of Holes 12 Both Side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		Drill Depth 20.5 mm	Tapping 18.4 mm
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		M.20 check by M.20	
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)		1 Hole close No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK	outside					Counter 460
2	External Relief Dia	5.5	(3-3)	Inner				Row 26
3	External Relief Depth		5 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