



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)

10595

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15886	36/50
2	Machined By		V.T.L M/c Shop	Dry No. Lec. 998.0
3	Pallet Die No.		15439	Rev. (00)
4	Die Category	Drg. No.	SSGW	
5	Out Side Diameter	Drg. No.	619.9 mm - Step OD	tapper. 12°
6	Inside Diameter	Drg. No.	520.14 mm	Step Length-18°
7	Width of Pellet Die	Drg. No.	222 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	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565 mm	Tapping No of Holes-12 Both side
13	Tapping Hole Diameter		M.20 Check By M.20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth-20.5 mm	Tapping depth-18°
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 5/9/25

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. 1 Hole Close

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

Counter-60°

1	Counter Sinking Depth & Finish	OK	outside	Inner	Row-38
2	External Relief Dia	3.5 mm	(3-3)	(14mm)	
3	External Relief Depth		20mm		
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark furnace		
6	Material Sent For Hardening On Date		5	9	25

Inspected By (Sign) & Date

Ravi 5/9/25

Reviewed by (Engineer-CNC)

Manager-QA