



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)

10654

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15779	31/50
2	Machined By		V.T.I M/c Shop	Day No 4450
3	Pallet Die No.		15764 - (9.8)mm	(Rev. 02)
4	Die Category	Drg. No.	Ten	
5	Out Side Diameter	Drg. No.	730mm Step OD 744mm	Tapper 10°
6	Inside Diameter	Drg. No.	630.14mm	Step Length 23.3mm
7	Width of Pellet Die	Drg. No.	290.6mm	Under Cut 7mm
8	Grooves as per Drawing	Drg. No.	15.3x8x5mm / 15.3x8x5	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	0.8mm Deep Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		685mm	of Holes 16
13	Tapping Hole Diameter		M.20 check by M.20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth	Tapping depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 6/9/25

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

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

Counter 60°

1	Counter Sinking Depth & Finish	OK	outside	Inner				Row 53
2	External Relief Dia	(3.9mm)	(3-3)	(19mm)				
3	External Relief Depth	5	25mm					
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date			6	9	25		

Inspected By (Sign) & Date

Ravi 6/9/25

Reviewed by (Engineer-CNC)

Manager-QA