



Lark Engineering Company (India) Pvt. Ltd.

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

10683

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.		15969	42/30
2	Machined By		V.T.L M/c Shop	Dry No. 1ea-9980
3	Pallet Die No.		14862 (4.5)mm	(Rev 002)
4	Die Category	Drg. No.	SSCW	
5	Out Side Diameter	Drg. No.	619.9mm	Step OD
6	Inside Diameter	Drg. No.	520.14 mm	Tabber-12
7	Width of Pellet Die	Drg. No.	222 mm	Step Length-18.5
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
12	Tapping PCD		565 mm	of Holes-12
13	Tapping Hole Diameter		M.20 check by M.20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth . 20.4mm	Tapping depth-18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 19/9/25

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

1	Counter Sinking Depth & Finish	OK	outside	Inner				Counter-60°
2	External Relief Dia	5.0mm	(3-3)	(8mm)				Row-29
3	External Relief Depth		13mm					
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date			19	9	25		

Inspected By (Sign) & Date

Ravi 19/9/25

Reviewed by (Engineer-CNC)

Manager-QA