



Lark Engineering Company (India) Pvt. Ltd.

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

10682

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.		15992	50/55
2	Machined By		V.T.I M/c Shop	Dry No: 1,2,3,4,5
3	Pallet Die No.		14387 (4.5)	Revised
4	Die Category	Drg. No.	890	
5	Out Side Diameter	Drg. No.	529.9 mm	Step oD: 498.8 mm
6	Inside Diameter	Drg. No.	420.14 mm	Tapper: 12°
7	Width of Pellet Die	Drg. No.	182 mm	Step length: 18 mm
8	Grooves as per Drawing	Drg. No.	12x8x3 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: 8
12	Tapping PCD		454 mm	Both Side
13	Tapping Hole Diameter		M20 Check by 420 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.4 mm	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 - 2 Hole Closes

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

Counter 260°

1	Counter Sinking Depth & Finish	OK						Row = 22
2	External Relief Dia	5.0 mm	Outside 2.2	Inner				
3	External Relief Depth		14 mm	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			19	9	25		

Inspected By (Sign) & Date

Ravi 19/9/25

Reviewed by (Engineer-CNC)

Manager-QA