



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16050	45/55
2	Machined By		V.T.L. M/c Shop	Dr. No. 13d-410
3	Pallet Die No.		15324 (8.0) mm	(Rev-01)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630 mm	Step OD 624 mm
6	Inside Diameter	Drg. No.	520.14 mm	Tapper - 12°
7	Width of Pellet Die	Drg. No.	186 mm	Step Length - 18 mm
8	Grooves as per Drawing	Drg. No.	13X8X3 mm 13X8X3 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 - 12°
12	Tapping PCD		565 mm	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 - 20.4 mm	Tapping depth - 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/9/25

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 2 - 14
2	External Relief Dia	8.5 mm	(3-3)	(10 mm)			
3	External Relief Depth		18 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			24	9	25	

Inspected By (Sign) & Date

Ravi 24/9/25

Reviewed by (Engineer-CNC)

Manager-QA