



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	Specifcation	Observations	Remarks
1	Work Order No.		16050	45/55
2	Machined By		V.T.I M/S Shop	Dry No-1cd-H10
3	Pallet Die No.		15538 (8.0)mm	(Rev: 01)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630mm	Step OD - 624mm
6	Inside Diameter	Drg. No.	520.14 mm	Tapper - 12°
7	Width of Pellet Die	Drg. No.	186mm	Step Length - 18mm
8	Grooves as per Drawing	Drg. No.	13x8x3 mm 13x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/S Shop	Tapping No
12	Tapping PCD		565 mm	of Holes - 12
13	Tapping Hole Diameter		M-20 check by H-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 - 18.4mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/9/25

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	Turner	Counter - 60°
2	External Relief Dia	(8.5 mm)	(3-3)	(10 mm)	Row - 14
3	External Relief Depth	18mm			
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		25 9 25		

Inspected By (Sign) & Date

Ravi 24/9/25

Reviewed by (Engineer-CNC)

Manager-QA