



Lark Engineering Company (India) Pvt. Ltd.

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

10746

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	Dry No. 1st. 410
3	Pallet Die No.		15539 (8.0) mm	(Rev: 01)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630 mm	Step OD = 623.8 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
12	Tapping PCD		565 mm	of Holes = 12
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 = 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 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	Twice	Counter-60
2	External Relief Dia	(8.5 mm)	(3-3)	(10 mm)	Row-14
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			25 9 25	

Inspected By (Sign) & Date

Ravi 25/9/25

Reviewed by (Engineer-CNC)

Manager-QA