



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

10056
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.		15153	34/44/50
2	Machined By		V.T.I. H/c Shop	Dy. M. Lark
3	Pallet Die No.		13254 (4.0) H/c	
4	Die Category	Drg. No.	SSS70	
5	Out Side Diameter	Drg. No.	619.9mm Step 00, 811.8mm	Step length 19.5
6	Inside Diameter	Drg. No.	520.14mm	
7	Width of Pellet Die	Drg. No.	1.80mm	
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		H/c Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		H/c Shop	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sao: 10/8/25

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								Counter 60°
2	External Relief Dia	4.5mm	5.0mm	4.5mm	All Pores 2 16mm					Sao: 25
3	External Relief Depth			5.0mm	All Pores 2 6mm					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date

Sao: 10/8/25

Reviewed by (Engineer-CNC)

Manager-QA