



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

10520

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.		15763	45/50
2	Machined By		V.T.L M/c SHOP	Dray No. 1st. 406
3	Pallet Die No.		15424 (3.2) mm	(Rev. 00)
4	Die Category	Drg. No.	SSCW	
5	Out Side Diameter	Drg. No.	62.02mm Step OD 62.2mm	Tapping - 12°
6	Inside Diameter	Drg. No.	32.6 - 14 mm	Step Length - 12 mm
7	Width of Pellet Die	Drg. No.	222 mm	Under Cut - 61
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 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 20.5 mm	Tapping Depth - 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/8/25

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	outside					Counter - 60°
2	External Relief Dia	3.8 mm	(3-3)		Inner			Row - 37
3	External Relief Depth		12mm		5mm			
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

Ravi 23/8/25

Reviewed by (Engineer-CNC)

Manager-QA