



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.		13754	38/45/50
2	Machined By		V.T.L N/c Shop	Drig No. 13.92959
3	Pallet Die No.		13695(4.0) n/c	Row 2
4	Die Category	Drig. No.	Extra wide	
5	Out Side Diameter	Drig. No.	6.0mm Step OD = 6.0mm	Tappers 12°
6	Inside Diameter	Drig. No.	5.0mm	Step length = 1.5mm
7	Width of Pellet Die	Drig. No.	2.2mm	Under cut = 0.1mm
8	Grooves as per Drawing	Drig. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drig. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	Tapping No. of Holes. 12 Both Side
12	Tapping PCD		5.65mm	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 2.0mm	Tapping Depth = 1.8mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/1/25

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 Rows	2 1.4mm				Row 2 91
3	External Relief Depth		5.0mm All Rows	2 5mm				
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

Inspected By (Sign) & Date

Ravi 11/1/25

Reviewed by (Engineer-CNC)

Manager-QA