



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13876	35/46
2	Machined By		V. T. L n/c Shop	Regular 1st 2013
3	Pallet Die No.		13060 (B.0) n/c	Revol
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	612 n/c, Step 60, 624 n/c	Step length 12 n/c
6	Inside Diameter	Drg. No.	520.12 n/c	Tapper 12°
7	Width of Pellet Die	Drg. No.	186 n/c	Undercut 6 n/c
8	Grooves as per Drawing	Drg. No.	14x8x5 n/c 14x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c. Shop	
12	Tapping PCD		56.5 n/c	Tapping No. of holes - 12 Back Side
13	Tapping Hole Diameter		M2.2 Check by M2.0 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 n/c	Tapping Depth 15.6 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/1/25

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

Counter Bore
Low - 30

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5 n/c	Outside (2-3)	Inner			
3	External Relief Depth		16 n/c	10 n/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Porrace				
6	Material Sent For Hardening On Date		9	1	25		

Inspected By (Sign) & Date

Ravi 9/1/25

Satya 9/1/25

Reviewed by (Engineer-CNC)

Manager-QA