



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.		13425	34/50
2	Machined By		V.T.L. N/C Shop	Drg No. LEC-998
3	Pallet Die No.		13467 (4.0) mm	Revised
4	Die Category	Drg. No.	2 outside	
5	Out Side Diameter	Drg. No.	619.8 mm Step on Tapper 12°	
6	Inside Diameter	Drg. No.	520.12 mm	Step length 18 mm
7	Width of Pellet Die	Drg. No.	222 mm	
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		N/C Shop	Tapping No. of Holes 12 Both Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		H20, Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 mm Tapping Depth 18.0 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Signature 6/1/25

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 - 1 Hole Colused

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 mm	outside (3-3)		Inner				
3	External Relief Depth		20 mm		16 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Porrace
6	Material Sent For Hardening On Date			6	1	25			

Inspected By (Sign) & Date

Signature 6/1/25

Signature 7/1/25

Reviewed by (Engineer-CNC)

Manager-QA