



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.		13910	31/50
2	Machined By		V.T.L H/c Shop	Dry hole L.S. Dr 35
3	Pallet Die No.		13551 (3.5) MM	Rev 200
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 MM	Step OD 892.9 MM
6	Inside Diameter	Drg. No.	600.12 MM	Step length 19 MM
7	Width of Pellet Die	Drg. No.	220 MM	
8	Grooves as per Drawing	Drg. No.	9.5 x 10 x 6 MM	9.5 x 10 x 6 MM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		645 MM	[Tapping No of holes 12 Both Side]
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 22.3 MM Tapping Depth 20.6 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 17/11/25

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 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0 MM	outside (3-3)		Inner				
3	External Relief Depth		2.3 MM		1.9 MM				
4	Inspection Done Before Hardening By (Name)								Sasi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		17	1	25				

Inspected By (Sign) & Date

Sasi 17/11/25

Sasi 17/11/25

Reviewed by (Engineer-CNC)

Manager-QA