



# 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)

9168

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14197	38/50
2	Machined By		V.T.L. N/c Shop	Digital 1.2.0.978
3	Pallet Die No.		13840(3.5) H4	Rev=00
4	Die Category	Drg. No.	Extenside	
5	Out Side Diameter	Drg. No.	6.20 H4	Step OD. Tapper, 12°
6	Inside Diameter	Drg. No.	5.20 H4	Step length 12.5
7	Width of Pellet Die	Drg. No.	22.2 H4	
8	Grooves as per Drawing	Drg. No.	13x8x5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H4	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	
12	Tapping PCD		56.5 H4	Tapping H. of Holes 12
13	Tapping Hole Diameter		H20 - Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 H4	Tapping Depth 8.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ins: 10/2/25

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 H4	Outside (2-3)		Inner				
3	External Relief Depth		16 H4		12 H4				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		10	2	25				

### Inspected By (Sign) & Date

Ins: 10/2/25

Reviewed by (Engineer-CNC)

Manager-QA