



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.		14285	45/50
2	Machined By		V.T.L. N/C Shop	Drg No. 1309980
3	Pallet Die No.		14184 (6.0) N/C	Rev 20
4	Die Category	Dr. No.	Ext. outside	
5	Out Side Diameter	Dr. No.	620 N/C, Step 001	Tappers 12°
6	Inside Diameter	Dr. No.	520.12 N/C	Step length 19.5
7	Width of Pellet Die	Dr. No.	222 N/C	
8	Grooves as per Drawing	Dr. No.	13x8x5 N/C 13x8x5 N/C	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping N of holes 12 Bot. Side
12	Tapping PCD		565 N/C	
13	Tapping Hole Diameter		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 N/C	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rao: 18/2/25

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	6.5 N/C	80% side (2-3)		inner				
3	External Relief Depth		11 N/C		5 N/C				
4	Inspection Done Before Hardening By (Name)				Rao				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		18	2	25				

Inspected By (Sign) & Date

Rao: 18/2/25

Satya
18/2/25
Reviewed by (Engineer-CNC)

Manager-QA