



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.		14465 ✓	45/50
2	Machined By		V.T.G. H/C Shop	Dy. No. 1.2.01/805
3	Pallet Die No.		13880 (G.O) ✓	Revised
4	Die Category	Drg. No.	M J & W	
5	Out Side Diameter	Drg. No.	70 mm / Step 00 - Tapper 12°	
6	Inside Diameter	Drg. No.	60 mm (A00.2 mm)	Step length 1.71
7	Width of Pellet Die	Drg. No.	265 mm	
8	Grooves as per Drawing	Drg. No.	15 x 8 x 7 mm / 15 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes 16 Both Side
12	Tapping PCD		640 mm ✓	
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 20 mm	Tapping Depth 8.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Saoi 6/2/25

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

C. counter, 60°

1	Counter Sinking Depth & Finish	ok							Saoi 98
2	External Relief Dia	6.5 mm	outside (13-3)		Inner				
3	External Relief Depth		11 mm		5 mm				
4	Inspection Done Before Hardening By (Name)								Saoi
5	Material Sent For Hardening By (Name)								Lark Forcace
6	Material Sent For Hardening On Date		06	03	25				

Inspected By (Sign) & Date

Saoi 6/3/25

Reviewed by (Engineer-CNC)

Manager-QA