



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.		14427	43/50
2	Machined By		V. T. L. N/C Shop	Dr. No. 12098
3	Pallet Die No.		13145(4.0)MM	Rev. 00
4	Die Category	Drg. No.	End sawide	
5	Out Side Diameter	Drg. No.	619.6MM Step 00. Tapper 12°	
6	Inside Diameter	Drg. No.	520.12MM	Step length 12.5
7	Width of Pellet Die	Drg. No.	222MM	
8	Grooves as per Drawing	Drg. No.	1378x5MM 1378x5MM	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping H. of Holes 12 Both Side
12	Tapping PCD		565MM	
13	Tapping Hole Diameter		M20 - Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2MM	Tapping Depth 8.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 11/3/25

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 80

1	Counter Sinking Depth & Finish	OK						Raw: 81
2	External Relief Dia	4.3MM	90° side (3.2)	Inner				
3	External Relief Depth		12MM	8MM				
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Look for no. 25
6	Material Sent For Hardening On Date		11	3	25			

Inspected By (Sign) & Date

Raw: 11/3/25

11/3/25

Reviewed by (Engineer-CNC)

Manager-QA