



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)

9597

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14822	35/55
2	Machined By		V.T.L. n/c Shop	Dry 4.0 62.0-457
3	Pallet Die No.		14564 (3.5) n/c	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	77.0mm, Step 0.0-8.0mm	Step 1.96
6	Inside Diameter	Drg. No.	66.012mm / 66.014mm	Under cut = 15mm
7	Width of Pellet Die	Drg. No.	315.9mm	
8	Grooves as per Drawing	Drg. No.	20x8x7.5mm / 20x8x7.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		72.5mm	
13	Tapping Hole Diameter		M20	Tapping Holes of holes 12
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 25.4mm	Tapping Depth 23.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi: 11/4/25	
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 - 1 Hole Colored	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok	Counter Bo: 25	
2	External Relief Dia	4.0mm	Outside 23-33	Inner 20mm
3	External Relief Depth		24mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ramesh	
6	Material Sent For Hardening On Date		11	4 25
Inspected By (Sign) & Date			Ravi: 11/4/25	

Reviewed by (Engineer-CNC)

Manager-QA