



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)

9677

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14689	40/45
2	Machined By		V.T.L. n/c Shop	Dy 4. 18.0.1295
3	Pallet Die No.		13035 (4.5)mm	Renew on
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510mm Step OD: 498.8	Tappet 12
6	Inside Diameter	Drg. No.	420.12mm	Step length=18mm
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454mm	Tapping H of holes: 8
13	Tapping Hole Diameter		M20 Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 18.4mm	Tapping Depth: 18.3
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/4/25

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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 80

1	Counter Sinking Depth & Finish	OK						Row 18
2	External Relief Dia	5.0mm	Outside (2.2)		Inner			
3	External Relief Depth		9mm		5mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Rorner
6	Material Sent For Hardening On Date		21	4	25			

Inspected By (Sign) & Date

Ravi 21/4/25

Reviewed by (Engineer-CNC)

Manager-QA