



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.		14786	36/45/50
2	Machined By		V.T.L. M/C Shop	Dr. No. 1-3.0.259
3	Pallet Die No.		13850 (4.0) M/C	Rev. 02
4	Die Category	Drg. No.	Extravide	
5	Out Side Diameter	Drg. No.	62mm Step 02. 623.6	Tabber. 12
6	Inside Diameter	Drg. No.	520.12mm	Step 10.4mm 218
7	Width of Pellet Die	Drg. No.	222mm	Under cut 21.8
8	Grooves as per Drawing	Drg. No.	13x8x5mm 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M2. Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 20.4mm	Tapping Depth. 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rev: 23/4/25

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 - 2 hole Coloured

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

Counter 60

1	Counter Sinking Depth & Finish	OK						Rev. 31
2	External Relief Dia	4.5mm/5.0mm	4.5mm	All Rows 2 14mm				
3	External Relief Depth		5.0mm	All Rows 2 5mm				
4	Inspection Done Before Hardening By (Name)			Rev:				
5	Material Sent For Hardening By (Name)			Lark Roshare				
6	Material Sent For Hardening On Date		23	4	25			

Inspected By (Sign) & Date

Rev: 23/4/25

Reviewed by (Engineer-CNC)

Manager-QA