



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.		14809	34/44/50
2	Machined By		V.T.L. N/C Shop	Dr. H. L. 10/03/12
3	Pallet Die No.		14642 (4.5) H	
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	62mm, Step on 61.9mm	Step length 19.5
6	Inside Diameter	Drg. No.	52.12mm	
7	Width of Pellet Die	Drg. No.	22.2mm	
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		N/C Shop	Tapping H. of holes 12
12	Tapping PCD		56.5mm	Bottom Side
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 20.4mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 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

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

Counter B. Ravi 23/4/25

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	5.0mm / 5.5mm	5.0mm	All Rows ~ 16mm			
3	External Relief Depth		5.5mm	All Rows ~ 6mm			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		23	4	25		

Inspected By (Sign) & Date

Ravi 23/4/25

Reviewed by (Engineer-CNC)

Manager-QA