



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.		14699	38/40
2	Machined By		V.T.L. n/c Shop	9109
3	Pallet Die No.		13525 (3.5)	Dg. n/c 3510
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	4.00 mm, Step 0.0, 0.95 mm	Step length 19.5
6	Inside Diameter	Drg. No.	3.212 mm	
7	Width of Pellet Die	Drg. No.	142 mm	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 mm 15.5 x 7 x 2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		355 mm	Tapping Holes 8
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm Tapping Depth 18.6 mm	
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 65
For 18

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.0 mm	Outside 2.2-2.5		Inner		
3	External Relief Depth		9 mm		2 mm		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		23	4	25		

Inspected By (Sign) & Date

Ravi 23/4/25

Reviewed by (Engineer-CNC)
23/4/25

Manager-QA