



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.		14879	45/50
2	Machined By		V.T.L. H/c Shop	Drg. No. 12.0.406
3	Pallet Die No.		13852 (3.2) H/c	Rev. No.
4	Die Category	Drg. No.	Extrusion Die	
5	Out Side Diameter	Drg. No.	62mm Step 00, 623.9mm	Tabber 12
6	Inside Diameter	Drg. No.	52.14mm	Step length 18mm
7	Width of Pellet Die	Drg. No.	222mm	Under cut 1.9mm
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		H/c Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M20: Check by M20 Bolt	Tapping H/c of holes 12
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
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			Raw: 10/5/25	
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 Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter 60°
2	External Relief Dia	3.8mm	Outside (3-3)	Raw 37
3	External Relief Depth		12mm	5mm
4	Inspection Done Before Hardening By (Name)		Raw	
5	Material Sent For Hardening By (Name)		Lark Purrace	
6	Material Sent For Hardening On Date		10	5
Inspected By (Sign) & Date			Raw: 10/5/25	

Reviewed by (Engineer-CNC)

Manager-QA