



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.		15066	33/47
2	Machined By		V.T.L. H/c Shop	1 Drg No. 1.2.0.875
3	Pallet Die No.		13854(2.8) H/c	Rev. 100
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	614 H/c Step 00. 623.5 H/c	Step length 18 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Under cut 4.8 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	Tapper 12°
8	Grooves as per Drawing	Drg. No.	13-8-5 H/c 13-8-5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		565 H/c	of H/c. 12
13	Tapping Hole Diameter		H/c. Check by H/c Bolt	Bolt Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c Tapping Depth 18.6 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw 9/6/25

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 60

1	Counter Sinking Depth & Finish	OK								Raw 40
2	External Relief Dia	3.3 H/c	83-85		Inner					
3	External Relief Depth		20 H/c		14 H/c					
4	Inspection Done Before Hardening By (Name)				Raw					
5	Material Sent For Hardening By (Name)				Lark Porrace					
6	Material Sent For Hardening On Date			9	6	25				

Inspected By (Sign) & Date

Raw 9/6/25

9/6/25

Reviewed by (Engineer-CNC)

Manager-QA