



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull Road, Yamuna Nagar - 135 001 (Haryana)

10049

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.			
2	Machined By		15136	36/50
3	Pallet Die No.		V.T.L H/c Shop	Dg. No. 13.0.893
4	Die Category	Drg. No.	13250(4.0) H/c	Rev. 01
5	Out Side Diameter	Drg. No.	38810	
6	Inside Diameter	Drg. No.	62.0 H/c Step 00. 62.2 H/c	② Tapper 12°
7	Width of Pellet Die	Drg. No.	52.14 H/c	Step length 20 H/c
8	Grooves as per Drawing	Drg. No.	186 H/c	Under cut 1.1 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c 13x8x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		56.5 H/c	[Tapping No. of Holes 12 Both Side]
13	Tapping Hole Diameter		H/c	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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									
2	External Relief Dia	4.5 H/c	20.5 H/c	33		Inner					
3	External Relief Depth		18 H/c			14 H/c					
4	Inspection Done Before Hardening By (Name)										
5	Material Sent For Hardening By (Name)										
6	Material Sent For Hardening On Date										

Inspected By (Sign) & Date

Ravi 9/6/25

Reviewed by (Engineer-CNC)

Manager-QA