



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.		1522-✓	418/50
2	Machined By		V. T. L. HLC Shop	Drg. No. 12.0.289
3	Pallet Die No.		14854 (4.0) mm	Rev. 01
4	Die Category	Drg. No.	2 subwide	
5	Out Side Diameter	Drg. No.	620 mm Step OD: 623.2 mm	Tapping: 12
6	Inside Diameter	Drg. No.	520.14 mm	Step length: 19.5
7	Width of Pellet Die	Drg. No.	222 mm	Under cut: 1.6 mm
8	Grooves as per Drawing	Drg. No.	14 x 8 x 5 mm / 14 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		HLC Shop	Tapping W. of H. 12
12	Tapping PCD		565 mm	Back 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: 22.4 mm Tapping Depth: 20	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sai: 17/6/25	
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 - 2 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	4.5 mm	Outside 2-31	Inner 2 mm
3	External Relief Depth		10 mm	
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		1st 6 25	
Inspected By (Sign) & Date			Sai: 17/6/25	

Reviewed by (Engineer-CNC)

Manager-QA