



Lark Engineering Company (India) Pvt. Ltd.

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

10/35

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.		15101 ✓	40/00
2	Machined By		V.T.L. n/a Shop	Dry H. 18.0. 742
3	Pallet Die No.		14919 (8.0) n/a	Rev 2.00
4	Die Category	Drg. No.	H. 7.0 mm h.	
5	Out Side Diameter	Drg. No.	7.20 mm, Step 00. 692.8 mm	Tabber 10
6	Inside Diameter	Drg. No.	600.14 mm	Step length 10
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 mm / 12 x 10 x 7.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/a Shop	
12	Tapping PCD		640 mm	
13	Tapping Hole Diameter		H. 20.0 Check by H. 20.0 B. 12	Tapping 2. of 4. 12. Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 20.4 mm	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rawi 23/6/25

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

Counters 30

1	Counter Sinking Depth & Finish	OK						Rawi 23/6/25
2	External Relief Dia	8.5 mm	Outside (2-3)	Inner				
3	External Relief Depth	2.5 mm		2.0 mm				
4	Inspection Done Before Hardening By (Name)			Rawi				
5	Material Sent For Hardening By (Name)			Lark Revenue				
6	Material Sent For Hardening On Date		23	6	25			

Inspected By (Sign) & Date

Rawi 23/6/25

23/6/25

Reviewed by (Engineer-CNC)

Manager-QA