



Lark Engineering Company (India) Pvt. Ltd.

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

10147

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		15305	24/50
3	Pallet Die No.		V.T.L. n/c Shop	Qty 100 1.20.9980
4	Die Category	Drg. No.	14711(6.0) H4	Rev. 00
5	Out Side Diameter	Drg. No.	8-12mm side	
6	Inside Diameter	Drg. No.	6.2mm Step 60mm Tapper 12°	
7	Width of Pellet Die	Drg. No.	520.14mm	Step length 18.5
8	Grooves as per Drawing	Drg. No.	222mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm / 13x8x5mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		565mm	
14	Tapping On Second Side	Half pitch of 1st side	H20 Check by H20 B-14	Tapping No. of Holes 12 Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4mm	Tapping Depth 18.5
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Sao: 24/6/25

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	6.5mm	Outside 83-33		Inner				
3	External Relief Depth		11mm		5mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		24	6	25				

Inspected By (Sign) & Date

Sao: 24/6/25

Reviewed by (Engineer-CNC)

Manager-QA