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.		151411	3415
2	Machined By		V.T.L M/C Shop	Dy.No. LR.CNC/25-1 Rev. 01
3	Pallet Die No.		14416 (B.O) Nos	
4	Die Category	Drg. No.	H. Tumbler	
5	Out Side Diameter	Drg. No.	70 mm Step OD = 69.23 mm	Taper = 12°
6	Inside Diameter	Drg. No.	60.14 mm	Step length = 2.5
7	Width of Pellet Die	Drg. No.	22.8 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 mm / 12 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/C Shop	Tapping M. of Holes 12 Both Side
12	Tapping PCD		64 mm	
13	Tapping Hole Diameter		M2 Check by M2 B-11	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 20.4 mm	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 21/6/25	
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 — 1 Hole Closed	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60 Ravi 39

1	Counter Sinking Depth & Finish	Ok						
2	External Relief Dia	13.5 mm	Both side (B-11)		Inner			
3	External Relief Depth		22 mm		16 mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Forge					
6	Material Sent For Hardening On Date		21	6	25			
	Inspected By (Sign) & Date		Ravi 21/6/25					

Satya 21/6/25

Reviewed by (Engineer-CNC)

Manager-QA