



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.			
2	Machined By		15305 ✓	32/5 ✓
3	Pallet Die No.		V.T.L. n/c Shop	Dry Holes 1 & 2 ✓
4	Die Category	Drg. No.	14488(4.0) n/c	Revised ✓
5	Out Side Diameter	Drg. No.	619.9 mm	Step 60.2 Tabber. 12"
6	Inside Diameter	Drg. No.	52.14 mm	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x25 5 mm / 13x25 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 mm	Tapping of holes 12
13	Tapping Hole Diameter		n/c Check by H20 Ball	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
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ins: 28/6/25

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 B: 28/6/25

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 mm	outside (3-3)		inner		
3	External Relief Depth		16 mm		12 mm		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		28	6	25		

Inspected By (Sign) & Date

Ins: 28/6/25

28/6/25

Reviewed by (Engineer-CNC)

Manager-QA