



Lark Engineering Company (India) Pvt. Ltd.

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

10295

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		15355 ✓	4-150
3	Pallet Die No.		V.T.L. M/c Shop	1 Dry Hole 12.0 1175
4	Die Category	Drg. No.	15504 (4.0) M	Rev 200
5	Out Side Diameter	Drg. No.	M36	
6	Inside Diameter	Drg. No.	700 M / Step 00. 709 M	Tapper 12
7	Width of Pellet Die	Drg. No.	600.14 M	Step length 20 M
8	Grooves as per Drawing	Drg. No.	260 M	Under cut = 1.4 M
9	Fitting Sizes on CNC Plate	Drg. No.	10x10x6 M / 10x10x6 M	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		645 M	
13	Tapping Hole Diameter		M20 : Check by M20 Bolt	Tapping Holes 12
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 22.4 M	Tapping Depth 20.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/7/25

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	4.5 M	Outside (3-3)		Inner				
3	External Relief Depth		14 M		10 M				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		18	7	25				

Inspected By (Sign) & Date

Ravi 18/7/25

Saty 18/7/25

Reviewed by (Engineer-CNC)

Manager-QA