



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.		15485	37145
2	Machined By		V.T.L. HLC Shop	Drg. No. 12749
3	Pallet Die No.		15740 (3.2) MM	Rev. 2.00
4	Die Category	Drg. No.	S910	
5	Out Side Diameter	Drg. No.	510 MM	Step length 17.5
6	Inside Diameter	Drg. No.	420.14 MM	
7	Width of Pellet Die	Drg. No.	182 MM	
8	Grooves as per Drawing	Drg. No.	12x8x3 MM / 12x8x3 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		HLC Shop	
12	Tapping PCD		454 MM	Tapping Holes of 2.8
13	Tapping Hole Diameter		M20: Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 MM	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/7/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		Nil

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

1	Counter Sinking Depth & Finish	OK							Counter 60°
2	External Relief Dia	3.8 MM	Outside 22-25		Inner 8 MM				Rev. 2.8
3	External Relief Depth		15 MM						
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Fur race
6	Material Sent For Hardening On Date		17	7	25				

Inspected By (Sign) & Date

Ravi 17/7/25

Satya 17/7/25

Reviewed by (Engineer-CNC)

Manager-QA