



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)

10499

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15819	32/5
2	Machined By		V. T. L. n/c Shop	10/10/2013
3	Pallet Die No.		14857 (3.0) n/c	20/10/2013
4	Die Category	Drg. No.	Ex. 20/10/2013	
5	Out Side Diameter	Drg. No.	219.9 mm	Step 00. Tapper 12.4"
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.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		H20. Check by H20 Ball	
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 20/8/25

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
Lower 38

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5 mm	Pub Side (23-3)	Inner			
3	External Relief Depth		17 mm	11 mm			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Purrace				
6	Material Sent For Hardening On Date		20	8	25		

Inspected By (Sign) & Date

Ravi 20/8/25

Satish 20/8/25

Reviewed by (Engineer-CNC)

Manager-QA