



Lark Engineering Company (India) Pvt. Ltd.

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

10816

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

Inprocess Inspection (Pilot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16064	35/50
2	Machined By		VTL m/c Shop	ISO 415 (Pilot)
3	Pallet Die No.		15894 (4.0)mm	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm	Step of 499 mm
6	Inside Diameter	Drg. No.	420 mm	Step length 20 mm
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm	Tapping No of
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Hole 8
10	Drilling Area Surface Smoothness		OK	Both side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 18.5	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Makegh 7/10/25

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

1	Counter Sinking Depth & Finish	OK						center 60
2	External Relief Dia	4.5 mm	outer (4-2)		inner			low 20
3	External Relief Depth		19.5 mm		15.5			
4	Inspection Done Before Hardening By (Name)		Makegh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		7	10	25			

Inspected By (Sign) & Date

Makegh 7/10/25

Sats 7/10/25

Reviewed by (Engineer-CNC)

Manager-QA