



Lark Engineering Company (India) Pvt. Ltd.

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

10890 4
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.		16050	40/50
2	Machined By		V.T.I. M/c Shop	Dray No 21221
3	Pallet Die No.		14334(4.0) 44	Revised
4	Die Category	Drg. No.	5987D	
5	Out Side Diameter	Drg. No.	620.1 44	Step OD = 623.9 44
6	Inside Diameter	Drg. No.	520.14 44	Step length 4.18 44
7	Width of Pellet Die	Drg. No.	186 44	Under cut 1.9 44
8	Grooves as per Drawing	Drg. No.	1348x3 44	1348x3 44
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		565 44	of Habel 212
13	Tapping Hole Diameter		M20.2 Check by M20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.5	Tapping depth = 18.4 44
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/10/25

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

Counter 285
Ravi 285

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5 44	73-31	Inner			
3	External Relief Depth	14 44		10 44			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date			15	10	25	

Inspected By (Sign) & Date

Ravi 15/10/25

Reviewed by (Engineer-CNC)

Manager-QA