



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.			
2	Machined By		13678 ✓	44/50 ✓
3	Pallet Die No.		N.T.C n/c Shop	By the 13.2.11.01
4	Die Category	Drg. No.	13886 (4.0) ✓	Rev. 02 ✓
5	Out Side Diameter	Drg. No.	Junior	(A)
6	Inside Diameter	Drg. No.	402.7 mm (A) 3 tap 002 381.4 mm (A)	Step length = 10.5
7	Width of Pellet Die	Drg. No.	304.12 mm / 303.8 mm (B. = 304.12) (A)	
8	Grooves as per Drawing	Drg. No.	95 mm ✓	Discuss with Neeves Sir
9	Fitting Sizes on CNC Plate	Drg. No.	9x6x9.5 mm / 9x6x8.5 mm ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		350 mm ✓	
14	Tapping On Second Side	Half pitch of 1st side	n/c = Check by Neeves B.I.L ✓	Tapping No. of Holes = 16 Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 15.2 mm Tapping Depth 13.5	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 4/1/25

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						Counter 60
2	External Relief Dia	4.5 mm	outside (2-2)	inner				Ravi 4/1/25
3	External Relief Depth		14 mm	6 mm				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Rurnone
6	Material Sent For Hardening On Date		4	1	25			

Inspected By (Sign) & Date

Ravi 4/1/25

Reviewed by (Engineer-CNC) *Satish 4/1/25*

Manager-QA