



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		13819	40/50
3	Pallet Die No.		V.T.L. HLC Shop	Dy. S. Lark 3910
4	Die Category	Drg. No.	13678(4.0)M	
5	Out Side Diameter	Drg. No.	Extrawide	
6	Inside Diameter	Drg. No.	620H, Step 602 612H	Step length, 19.5
7	Width of Pellet Die	Drg. No.	520.12H	
8	Grooves as per Drawing	Drg. No.	222H	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5H / 13x8x5H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		NLC Shop	
12	Tapping PCD		565H	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2H	Tapping Depth 18.6H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Tapping dia of hole 2.12
Roh Side

Inspected By (Sign) & Date

Ravi 7/11/25

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 31

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5H	Outside (2-3)	Inner			
3	External Relief Depth		14H	10H			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		7	1	25		

Inspected By (Sign) & Date

Ravi 7/11/25

Sotya 7/11/25

Reviewed by (Engineer-CNC)

Manager-QA