



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.		13837 ✓	40/50
2	Machined By		N.T.L. n/c Shop	Dry the work 8355
3	Pallet Die No.		13704 (4.0) ✓	8310
4	Die Category	Drg. No.	Ext outside ✓	
5	Out Side Diameter	Drg. No.	6.20 H4 ✓ Step 00 - 612 H4 ✓	Step length 19.5 ✓
6	Inside Diameter	Drg. No.	5.20 I2 H4 ✓	
7	Width of Pellet Die	Drg. No.	2.22 H4 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 H4 13x8x5 H4 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes of Holes - 12 Both Side
12	Tapping PCD		56.5 H4 ✓	
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: 20.2 H4 Tapping Depth: 18.0 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/1/25

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

Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 H4	Outside (3-3)		Inner				
3	External Relief Depth	✓	14 H4		10 H4				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		9		1	25			

Inspected By (Sign) & Date

Ravi 9/1/25

Sats 9/1/25

Reviewed by (Engineer-CNC)

Manager-QA