



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.		13783	19/66
2	Machined By		V.T.L. H/c Shop	Drilling 13.0.2009
3	Pallet Die No.		14000 (6.0) H/c	Row 23
4	Die Category	Drg. No.	H. Tomba	
5	Out Side Diameter	Drg. No.	680.7 H/c	Step 60. 693 H/c
6	Inside Diameter	Drg. No.	546.12 H/c	(Row 2 543.3 H/c) Step length 3 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Width of 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 H/c	(32.7 x 9.2 H/c) (4.8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2 H/c	Tapping Depth 31.5
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				
1	Counter Sinking Depth & Finish	ok		Counter 30° Row 12
2	External Relief Dia	7.5 H/c	All Rows	
3	External Relief Depth		4.7 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Forncel	
6	Material Sent For Hardening On Date		9 1 25	
Inspected By (Sign) & Date			Ravi 9/1/25	

Reviewed by (Engineer-CNC)
 Satoru 9/1/25

Manager-QA