



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.		13862 ✓	45/50 ✓
2	Machined By		V.T.L. n/a Shop	Dy. No. Lark 3570 ✓
3	Pallet Die No.		13708 (5.0) ✓	
4	Die Category	Drg. No.	Endsawide	
5	Out Side Diameter	Drg. No.	620 H4 ✓ Step 002 612 H4	Step length 19.5 ✓
6	Inside Diameter	Drg. No.	520.12 H4 / 520.14 H4 (A)	
7	Width of Pellet Die	Drg. No.	222 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/a Shop	Tapping of holes - 12 Both Side
12	Tapping PCD		565 H4 ✓	
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 20.2 H4	Tapping Depth 18.6 H4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/1/25

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	5.5 H4 ✓	Outside (3-3)		Inner		Ravi 26
3	External Relief Depth		10 H4		5 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		10	1	25		

Inspected By (Sign) & Date

Ravi 10/1/25

Sats 10/1/25
Reviewed by (Engineer-CNC)

Manager-QA