



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.		13382	38/50
2	Machined By		V. T. L. N/A Shop	Dr. No. 1.3.0.153
3	Pallet Die No.		14064 (6.0) H/H	Rev. No.
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/H / Step OD = 491 H/H	Step length = 16.5
6	Inside Diameter	Drg. No.	420.12 H/H	
7	Width of Pellet Die	Drg. No.	160 H/H	
8	Grooves as per Drawing	Drg. No.	12x9x3 H/H / 12x9x3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping No. of Holes: 8 Bolt Side
12	Tapping PCD		454 H/H	
13	Tapping Hole Diameter		ø31.4" ± Check by ø31.4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.2 H/H Tapping Depth: 18	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi: 31/7/25

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	6.5 H/H	Outside (2-2)		Inner				
3	External Relief Depth		18 H/H		12 H/H				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)		R.R						
6	Material Sent For Hardening On Date		6		25				

Inspected By (Sign) & Date

Ravi: 31/7/25

Reviewed by (Engineer-CNC)

Manager-QA