



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.		13640 ✓	33/50 ✓
2	Machined By		V.T.L. H/c Shop	Dr. No. 12.0.403
3	Pallet Die No.		13182(4.0) H/c	Rev. 00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/c Step 00 491 H/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.14 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8+3 H/c 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes, 8 Both side
12	Tapping PCD		454 H/c ✓	
13	Tapping Hole Diameter		0314" ✓ Check by 0314" P	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 18.2 H/c	Tapping Depth, 16.8 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 6/11/25	
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				
1	Counter Sinking Depth & Finish	ok	Counter 60 Rev. 20	
2	External Relief Dia	4.5 H/c	Outside (2-2)	Inner
3	External Relief Depth		16 H/c	12 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		6	25
Inspected By (Sign) & Date			Ravi 6/11/25	

Reviewed by (Engineer-CNC)

Manager-QA