



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.		14001 ✓	43/55 ✓
2	Machined By		V.T.L. N/C Shop	Dy. No. 6-20-14 934
3	Pallet Die No.		13583(3.0) H.H.	Rev. 00 ✓
4	Die Category	Drg. No.	Endsawide	
5	Out Side Diameter	Drg. No.	629.8 H.H. Ⓣ Step 00.6 H.H.	Step length 19.4 ✓
6	Inside Diameter	Drg. No.	520.12 H.H.	
7	Width of Pellet Die	Drg. No.	222 H.H.	
8	Grooves as per Drawing	Drg. No.	13x8x5 H.H. / 13x8x5 H.H.	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		56.5 H.H. ✓	
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 H.H.	Tapping Depth 18.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/11/25

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°
2	External Relief Dia	3.5 H.H. ✓	Outside (3.3)		Inner			Rev. 35
3	External Relief Depth		13 H.H. ✓		7 H.H. ✓			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		22	1	25			

Inspected By (Sign) & Date

Ravi 22/11/25

Satish 22/11/25

Reviewed by (Engineer-CNC)

Manager-QA