



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		13851 ✓	32/50 ✓
3	Pallet Die No.		V.T.L. H/c Shop	Dy H/c 1.32 ✓ 1141
4	Die Category	Drg. No.	13058 (4.0) H/c ✓	Rev 200 ✓
5	Out Side Diameter	Drg. No.	35570	
6	Inside Diameter	Drg. No.	62.0 H/c ✓	Step 00.1 62.2 H/c ✓
7	Width of Pellet Die	Drg. No.	52.0.3 H/c ✓	52.12 H/c ✓
8	Grooves as per Drawing	Drg. No.	186 H/c ✓	Tapper 12° ✓
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 H/c 13x8x3 H/c ✓	Step length 2.2 H/c ✓
10	Drilling Area Surface Smoothness		ok	Under cot 1.4 H/c ✓
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c ✓	Tapping H/c of holes 12° Both Side
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 2.2 H/c ✓	Tapping Depth 1.8 H/c ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi: 10/11/25

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	4.5 H/c ✓	outside (3-3)		Inner			Rev 25
3	External Relief Depth		22 H/c ✓		18 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		10	1	25			

Inspected By (Sign) & Date

Ravi: 10/11/25

Reviewed by (Engineer-CNC)

Manager-QA