



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8971

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.		13858	55/55
2	Machined By		V.T.L. H/c Shop	Dr. No. 1.2.0.14951
3	Pallet Die No.		13580 (4.5) H/c	R20 = 0.02
4	Die Category	Drg. No.	End saw side	
5	Out Side Diameter	Drg. No.	629.8 H/c	
6	Inside Diameter	Drg. No.	Step 02 = 621.5 H/c	Tap hole = 12
7	Width of Pellet Die	Drg. No.	520.3 H/c	Step length = 21.5
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c 13x8x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping No. of holes = 12 Both side
13	Tapping Hole Diameter		565 H/c	
14	Tapping On Second Side	Half pitch of 1st side	H20. Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.3 H/c	Tapping Depth = 18.6 H/c
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 11/1/25

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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						Countersink
2	External Relief Dia	5.0 H/c	outside (3-3)		Inner			Row = 29
3	External Relief Depth		5 H/c		Mill			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			11	1	25		

Inspected By (Sign) & Date

Ravi 11/1/25

Setu 11/1/25

Reviewed by (Engineer-CNC)

Manager-QA