



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.		1389G	32/40
2	Machined By		V.T.L. n/c Shop	Dy No. 1.2.0.942
3	Pallet Die No.		1371G (3.0) n/c	Rev: 00
4	Die Category	Drg. No.	External	
5	Out Side Diameter	Drg. No.	600 n/c	Step OD = 621.5 n/c
6	Inside Diameter	Drg. No.	520.12 n/c	Step length = 31.5
7	Width of Pellet Die	Drg. No.	222 n/c	Undercut = 10.75
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 22 n/c	Tapping Depth = 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 11/1/25	
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: 37
2	External Relief Dia	3.3 n/c	All Rows	
3	External Relief Depth		2 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Forging	
6	Material Sent For Hardening On Date		11 / 1 / 25	
Inspected By (Sign) & Date			Ravi 11/1/25	

Reviewed by (Engineer-CNC) *Satish 13/1/25.*

Manager-QA