



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.			
2	Machined By		13809	40/40
3	Pallet Die No.		V.T.L n/c Shop	By M/s Lark 2195
4	Die Category	Drg. No.	13045 (5.0) H.H.	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 H.H. Step OD: 496.9 H.H.	Step length 14.5
7	Width of Pellet Die	Drg. No.	420.12 H.H.	
8	Grooves as per Drawing	Drg. No.	158 H.H.	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H.H. / 10x8x3 H.H.	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of holes: 8 Both Side
13	Tapping Hole Diameter		454 H.H.	
14	Tapping On Second Side	Half pitch of 1st side	M20x2 Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 18.3 H.H. Tapping Depth: 16.6 H.H.	
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 17/11/25

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						Count etc 60°
2	External Relief Dia	5.5 H.H.	outside (2.25)	Inner				Row 2/19
3	External Relief Depth		5 H.H.	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		17	1	25			

Inspected By (Sign) & Date

Ravi 17/11/25

Sotya 17/11/25

Reviewed by (Engineer-CNC)

Manager-QA