



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.		14079 ✓	36/40 ✓
2	Machined By		V. T. L. H/c Shop	Dr. No. 13.02 1348
3	Pallet Die No.		13220 (3.0) H/H	Rev. 2.00 ✓
4	Die Category	Dr. No.	3210	
5	Out Side Diameter	Dr. No.	500 H/H / Step 00 = 492 H/H	Step length 17.5
6	Inside Diameter	Dr. No.	420.12 H/H	
7	Width of Pellet Die	Dr. No.	181.9 H/H	
8	Grooves as per Drawing	Dr. No.	12x8x3 H/H / 12x8x3 H/H	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		455 H/H	Tapping No. of Holes, 8 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 18.3 H/H	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/2/25

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							Counters 60°
2	External Relief Dia	3.5 H/H	outside (2-2)		inner				Rev. 30
3	External Relief Depth		10 H/H		4 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			1	2	25			

Inspected By (Sign) & Date

Ravi 11/2/25

Satish 11/2/25

Reviewed by (Engineer-CNC)

Manager-QA