



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.		14209 ✓	33/40 ✓
2	Machined By		V.T.L n/c shop	Dy. n/c 18.02.15 ✓
3	Pallet Die No.		13563(3.0) n/c ✓	Reverse ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c Step 00. 498.88	Tappers 12 ✓
6	Inside Diameter	Drg. No.	410.12 n/c ✓	Step length 18 n/c ✓
7	Width of Pellet Die	Drg. No.	158 n/c ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c 12 x 8 x 3 n/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c shop	Tapping No of holes 8 Both Side
12	Tapping PCD		454 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 18.3 n/c	Tapping Depth 18.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/2/25

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

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

1	Counter Sinking Depth & Finish	ok							Counter Gei Ravi 24
2	External Relief Dia	3.3 n/c	outside (2.2)		Inner				
3	External Relief Depth	✓	13 n/c		7 n/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		1	2	25				

Inspected By (Sign) & Date

Ravi 11/2/25

Reviewed by (Engineer-CNC)
Sethi 11/2/25

Manager-QA