



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.		13974 ✓	35/40 ✓
2	Machined By		V. T. L. n/c Shop	Dry H. = 63.0 = 282
3	Pallet Die No.		13219(3.5) n/c ✓	Rev = 00 ✓
4	Die Category	Dr. No.	SEW	
5	Out Side Diameter	Dr. No.	499.9 n/c ✓	Step OD = 491 n/c ✓
6	Inside Diameter	Dr. No.	420.12 n/c ✓	Step length 17 n/c ✓
7	Width of Pellet Die	Dr. No.	182 n/c ✓	
8	Grooves as per Drawing	Dr. No.	10x10x5 n/c / 10x10x5 n/c ✓	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		455 n/c ✓	Tapping dia of Holes: 8 Both Side
13	Tapping Hole Diameter		03/4" - Check by 003/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19.3 n/c ✓	Tapping Depth = 17.6 ✓
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

Counter = 60
Rows = 27

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.0 n/c ✓	outside (2-2)		Inner		
3	External Relief Depth		8 n/c ✓		5 n/c ✓		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Porace		
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