



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

9/4/

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13740/	45/50 ✓
2	Machined By		V.T.L. N/C Shop	1 Drg. No. L.E.C. 1376
3	Pallet Die No.		14845 (6.0) ✓	Rev. No. 2 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.6 mm Ⓢ	Step OD, 491 mm, Step length 17.5
6	Inside Diameter	Drg. No.	420.12 mm ✓	
7	Width of Pellet Die	Drg. No.	158 mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm / 12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping of holes B Back side
12	Tapping PCD		454 mm ✓	
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 mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 3/2/25

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

Count 21 - 60

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	6.5 mm	Outside 2.25		Inner			
3	External Relief Depth		11 mm		5 mm			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		3	2	25			

Inspected By (Sign) & Date

Ravi 3/2/25

Satya 3/2/25

Reviewed by (Engineer-CNC)

Manager-QA