



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.		13853 ✓	30/50 ✓
2	Machined By		V.T.L. N/C Shop	Drg. No. 1202 1050
3	Pallet Die No.		14322 (3.0) ✓	Rev. No. ✓
4	Die Category	Drg. No.	Jumbo. (A31)	
5	Out Side Diameter	Drg. No.	75.0mm ✓ Step 002 743.5mm ✓	Tabber 10'
6	Inside Diameter	Drg. No.	63.0 ± 0.12 mm ✓	Step Length 23mm ✓
7	Width of Pellet Die	Drg. No.	26.5mm ✓	
8	Grooves as per Drawing	Drg. No.	15 × 8 × 5 mm ✓ 15 × 8 × 5mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		68.5mm ✓	Tapping dia of holes 15 Both Side
13	Tapping Hole Diameter		14.20 ✓ Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3mm ✓ Tapping Depth 19.5mm ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date		Ravi 5/2/25	
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 - 2 Hole Closed (A)

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

1	Counter Sinking Depth & Finish	ok						Counter = 60° Ravi = 48
2	External Relief Dia	—	—	No - Relief				
3	External Relief Depth	—	—	—				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Shri Keshav				
6	Material Sent For Hardening On Date		5	2	25			

Inspected By (Sign) & Date		Ravi 5/2/25	
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Reviewed by (Engineer-CNC)

Manager-QA