



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.		14263 ✓	33/40 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. LAC.15062
3	Pallet Die No.		13564 (3.0) H4 ✓	Revised ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H4 ✓	Step 00, 498.8, Tapper, 12°
6	Inside Diameter	Drg. No.	420.12 H4 ✓	Step length 13 H4 ✓
7	Width of Pellet Die	Drg. No.	158 H4 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H4 / 12x8x3 H4 ✓	
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 Back Side
12	Tapping PCD		454 H4 ✓	
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 H4 ✓	Tapping Depth 16.6 H4 ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Soni 10/8/25

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							C. counter B ^o
2	External Relief Dia	3.3 H4 ✓	Outside (2-2)		Inner				Rev: 24
3	External Relief Depth		13 H4 ✓		7 H4 ✓				
4	Inspection Done Before Hardening By (Name)								Soni
5	Material Sent For Hardening By (Name)								Lark Forward
6	Material Sent For Hardening On Date		10	2	25				

Inspected By (Sign) & Date

Soni 10/8/25

Reviewed by (Engineer-CNC)

Manager-QA