



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

9/70

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14204 ✓	45/50 ✓
3	Pallet Die No.		V.T.L H/c Shop	Dy. H/c L.2.0298
4	Die Category	Drg. No.	14169(5.0) H/c	Rev. 2.00 ✓
5	Out Side Diameter	Drg. No.	Fit outside	
6	Inside Diameter	Drg. No.	620 H/c Step OD Tapper 12°	
7	Width of Pellet Die	Drg. No.	520.12 H/c	Step Length 2.18 H/c
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping H/c of holes 12° Both Side
13	Tapping Hole Diameter		565 H/c	
14	Tapping On Second Side	Half pitch of 1st side	H202 Check by H20 Bell	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.3 H/c Tapping Depth 18.6 H/c	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 10/2/25

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 Sink
2	External Relief Dia	5.3 H/c	Outside (3-3)		Inner			Rev. 2.00
3	External Relief Depth		10 H/c		5 H/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		10	2	25			

Inspected By (Sign) & Date

Ravi 10/2/25

Reviewed by (Engineer-CNC)

Manager-QA