



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.		14201 ✓	45/45 ✓
2	Machined By		V.T.L. H/c Shop	Dr. No. 18.01 52
3	Pallet Die No.		12860 (2.8) H/c	Rev. 100 ✓
4	Die Category	Drg. No.	⊕ Senior	
5	Out Side Diameter	Drg. No.	509.8 H/c Step OD. 490.8 H/c	Step length 7.5
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8r3 H/c / 12x8r3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of holes = 8 Back Side
12	Tapping PCD		454 H/c ✓	
13	Tapping Hole Diameter		⊕ 3/16" Check by 3/16" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 H/c Tapping Dept. 16.6 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/3/25

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. of Holes Colused ⊕

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

Counter = 60

1	Counter Sinking Depth & Finish	ok							Rev. 96
2	External Relief Dia	3.1 H/c	Outside (2.2)	Inner					
3	External Relief Depth		6 H/c	Mill					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		6	3	25				

Inspected By (Sign) & Date

Ravi 6/3/25

Satya 6/3/25

Reviewed by (Engineer-CNC)

Manager-QA