



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.		14106	40/50
2	Machined By		V. T. L. H/c Shop	Dr. No. 1.25/148.5
3	Pallet Die No.		13874 (4.0) H/c	Rev. 02
4	Die Category	Drg. No.	M J 40	
5	Out Side Diameter	Drg. No.	701 H/c 8 Step OD Tappers 12"	
6	Inside Diameter	Drg. No.	600.12 H/c / 600.2 H/c	Step length 17.1 H/c
7	Width of Pellet Die	Drg. No.	265 H/c	
8	Grooves as per Drawing	Drg. No.	15x8x7 H/c / 15x8x7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of holes 16 Back Side
12	Tapping PCD		640 H/c	
13	Tapping Hole Diameter		M20 C. back by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/c Tapping Depth 18.5 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 27/7/25

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						Counters 60
2	External Relief Dia	4.5 H/c	90K side (3-3)		Inner			Rows 39
3	External Relief Depth		14 H/c		10 H/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		27	2	25			

Inspected By (Sign) & Date

Ravi 27/7/25

Sats 27/7/25

Reviewed by (Engineer-CNC)

Manager-QA