



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.		13956 ✓	G-186
2	Machined By		V. T. L. n/c Shop	130
3	Pallet Die No.		14538 (3.5) ✓	Rev. 01
4	Die Category	Drg. No.	S. Tomba	
5	Out Side Diameter	Drg. No.	1032.2mm Step 002 1033mm	Tapper 3°
6	Inside Diameter	Drg. No.	900.2 mm	Step length 37mm
7	Width of Pellet Die	Drg. No.	375 mm	Under cut 0.4mm
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 mm / 29.5 x 8 x 13	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of 4.15 Both Side
12	Tapping PCD		970mm	
13	Tapping Hole Diameter		M242 Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 88.3 mm	Tapping Depth 86.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/3/25

1	As per programme no.			2 810 L 39.1 mm wire dia 7.5 mm Deep Both Side
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

Completed by

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0 mm	Outside (4.0 mm)	Inner					
3	External Relief Depth		13 mm	6 mm					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Process						
6	Material Sent For Hardening On Date		10	3	25				

Inspected By (Sign) & Date

Ravi 10/3/25

Satya 10/3/25

Reviewed by (Engineer-CNC)

Manager-QA