



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.		14397	30/40
2	Machined By		V.T.L. n/c Shop	Drilling 1.2.0.700
3	Pallet Die No.		13570(2.8)mm	Rev. 01
4	Die Category	Drg. No.	59.10	
5	Out Side Diameter	Drg. No.	500mm Step on 491.2mm Step length 1.7mm	
6	Inside Diameter	Drg. No.	420.12mm	
7	Width of Pellet Die	Drg. No.	182mm	
8	Grooves as per Drawing	Drg. No.	10x9.5x5mm 10x9.5x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		457mm	of holes 8
13	Tapping Hole Diameter		M20 : Check by M20 Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2mm Tapping Depth 18.9mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 12/8/25

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						Counter = 60
2	External Relief Dia	3.3mm	outside (2-25)		inner			now = 31
3	External Relief Depth		13mm		10mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		17	3	25			

Inspected By (Sign) & Date

Ravi 12/8/25

Reviewed by (Engineer-CNC)

Manager-QA