



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 (Pellot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14713	40/40
2	Machined By		V.T.L. H/c Shop	By the Lark 9510
3	Pallet Die No.		13982 (4.0) H/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c, Step 00. 490.8	Step length 17.5
6	Inside Diameter	Drg. No.	480.12 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H20, Chade by H20 8-11	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 H/c	Tapping Depth 18.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Soni 5/4/25

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

Counter As
Soni 20

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.3 H/c	Outside 2.25		Inner		
3	External Relief Depth		4 H/c		Nil		
4	Inspection Done Before Hardening By (Name)		Soni				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		5	4	25		

Inspected By (Sign) & Date

Soni 5/4/25

Reviewed by (Engineer-CNC)
Soni 5/4/25

Manager-QA