



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.		9749	37/50
2	Machined By		V.T.L M/C Shop	Dy No. L.S.O. 259
3	Pallet Die No.		9994 (3.0) M	Rev. 02
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	620 M Step 00, 622.5 M	Tapet = 12°
6	Inside Diameter	Drg. No.	520.12 M	Step length = 18 M
7	Width of Pellet Die	Drg. No.	222 M	Under cut = 1.3 M
8	Grooves as per Drawing	Drg. No.	13x8x5 M 13x8x5 M	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		565 M	
13	Tapping Hole Diameter		M 20x Check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20 M Tapping Dept. = 18 M	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 20/6/25

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								Ravi 28
2	External Relief Dia	3.5 M	outside (3-3)	Inner						
3	External Relief Depth		19 M	13 M						
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		20	6	23					

Inspected By (Sign) & Date Ravi 20/6/25

Reviewed by (Engineer-CNC) 21/6/25

Manager-QA