



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.		14927	33/40
2	Machined By		V.T.C. M/C Shop	209
3	Pallet Die No.		13755(3.0) M	210
4	Die Category	Drg. No.	380	
5	Out Side Diameter	Drg. No.	500 M, Step 00: 491 M	Step length 17.5
6	Inside Diameter	Drg. No.	480.12 M	
7	Width of Pellet Die	Drg. No.	182 M	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 M	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 M	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		454 M	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4 M	Tapping Depth: 18.5 M
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 11/5/25

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. Re: 20 x 30
2	External Relief Dia	3.5 M	Outside (2.2)		Inner					
3	External Relief Depth		13 M		7 M					
4	Inspection Done Before Hardening By (Name)									Raw:
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			5	25					

Inspected By (Sign) & Date

Raw: 11/5/25

Reviewed by (Engineer-CNC)

Manager-QA