



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)

9837

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14910	83/4-1
2	Machined By		V. T. L. H/c Shop	9837
3	Pallet Die No.		13221 (4.0) H/c	9837
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4.00 H/c	Step length 14.0
6	Inside Diameter	Drg. No.	3.20 H/c	
7	Width of Pellet Die	Drg. No.	14.2 H/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	15.5 x 7 x 2 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		355 H/c	
13	Tapping Hole Diameter		H/c Check by H/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rev: 10/5/25

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							
2	External Relief Dia	4.5 H/c	Outside 2.2		Inner				
3	External Relief Depth		11 H/c		7 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		10	5	25				

Inspected By (Sign) & Date

Rev: 10/5/25

Reviewed by (Engineer-CNC)

Manager-QA