



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.		15229	33/38
2	Machined By		V. T. L. H/C Shop	Dry No. 13.0.936
3	Pallet Die No.		14609 (3.0) H/C	Rev 100
4	Die Category	Drg. No.	H76 N	
5	Out Side Diameter	Drg. No.	676 mm / Step 00. 692 mm	Step length 2
6	Inside Diameter	Drg. No.	600.12 mm	Outer cut 18 mm
7	Width of Pellet Die	Drg. No.	265 mm	
8	Grooves as per Drawing	Drg. No.	15x8x7 mm / 15x8x7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		640 mm	
13	Tapping Hole Diameter		H202 Check by H20 B. 1	Tapping Holes of Holes 13 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

San: 24/6/25

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						Counter 20
2	External Relief Dia	3.5 mm		All Rows				Rows 46
3	External Relief Depth			5 mm				
4	Inspection Done Before Hardening By (Name)			San				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		24	6	25			
Inspected By (Sign) & Date		San: 24/6/25						

Reviewed by (Engineer-CNC)

Manager-QA