



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10226

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.			
2	Machined By		15282 ✓	33/4 ✓
3	Pallet Die No.		V-T.L. 4/0 Shop	Drg No. 12.9.2005
4	Die Category	Drg. No.	15596 (3.0) 4.4	Rev 2.00
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	39mm Step on 383mm Step length 11.5	
7	Width of Pellet Die	Drg. No.	310.14mm	
8	Grooves as per Drawing	Drg. No.	135mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm / 12x8x3mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		4/0 Shop	Tapping 4.1.7 of holes 8 Back Side
13	Tapping Hole Diameter		350mm	
14	Tapping On Second Side	Half pitch of 1st side	03/4" 2 Check by 03/4" Rule	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 5/7/25

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 60

1	Counter Sinking Depth & Finish	ok							Raw 20
2	External Relief Dia	3.3mm	Outside 2-2.5		Inner				
3	External Relief Depth		13mm		7mm				
4	Inspection Done Before Hardening By (Name)								Raw:
5	Material Sent For Hardening By (Name)								Lark Parnace
6	Material Sent For Hardening On Date			5	7	25			

Inspected By (Sign) & Date

Raw: 5/7/25

Reviewed by (Engineer-CNC)

Manager-QA