



Lark Engineering Company (India) Pvt. Ltd.

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

10258

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		15363 ✓	45/50 ✓
3	Pallet Die No.		V. T. L. H/c Shop	Drilling 12.0.106
4	Die Category	Drg. No.	14867 (3.2) H/c	Revised
5	Out Side Diameter	Drg. No.	2nd side	
6	Inside Diameter	Drg. No.	Q20 H/c Shop 02. Q22.2 H/c	Tapping 12
7	Width of Pellet Die	Drg. No.	520.14 H/c	Step length 18 mm
8	Grooves as per Drawing	Drg. No.	222 H/c	Under cut 12 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		56.5 H/c	of H/c 12
13	Tapping Hole Diameter		H/c. Check by H/c B. 12	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 9/7/25	
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				
1	Counter Sinking Depth & Finish	OK		Consider 60°
2	External Relief Dia	2.8 H/c	2nd side (2-3)	Inner
3	External Relief Depth	12 H/c	5 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		9 7 25	
Inspected By (Sign) & Date			Ravi 9/7/25	

Reviewed by (Engineer-CNC)

Manager-QA