



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.		15482	44/50
2	Machined By		V.T.L. N/C Shop	Dry H.. 1.90 998
3	Pallet Die No.		14804(4.0) H	Rev. 1.00
4	Die Category	Drg. No.	End side	
5	Out Side Diameter	Drg. No.	619.9 H	Step 00. Tappers 12
6	Inside Diameter	Drg. No.	520.14 H	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H / 13x8x5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		565 H	
13	Tapping Hole Diameter		H20.2 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 15/7/25	
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		
2	External Relief Dia	4.5 H	Outer 3.33	Inner 6 H
3	External Relief Depth		14 H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		15 7 25	
Inspected By (Sign) & Date			Ravi 15/7/25	

Reviewed by (Engineer-CNC)

Manager-QA