



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)

10310

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15462 ✓	42155
2	Machined By		V. T. L. H/c Shop	Drilling No. 12.0 = 35
3	Pallet Die No.		13899 (4.0) H/H	Rev. 00
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	630 H/H, Step 00, G12 H/H, Step length 20mm	
6	Inside Diameter	Drg. No.	520.14 H/H	
7	Width of Pellet Die	Drg. No.	186 H/H	
8	Grooves as per Drawing	Drg. No.	13482 3 H/H / 13482 3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	[Tapping H/c of holes. 12 Both Side]
12	Tapping PCD		565 H/H	
13	Tapping Hole Diameter		H20, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/H	Tapping Depth 18.4 H/H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/7/25

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 Bore

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.5 H/H	Outside 3.8		Inner				
3	External Relief Depth		17 H/H		13 H/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		21	7	25				

Inspected By (Sign) & Date

Ravi 21/7/25

21/7/25

Reviewed by (Engineer-CNC)

Manager-QA