



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.		15478	36/50
2	Machined By		V.T.L. H/c Shop	Drg No. 18.0.369
3	Pallet Die No.		14724(4.0)H	Rev: 00
4	Die Category	Drg. No.	53310	
5	Out Side Diameter	Drg. No.	620H	Step 00: 620 3H
6	Inside Diameter	Drg. No.	520.14H	Tabber 12"
7	Width of Pellet Die	Drg. No.	190H	Step length 20H
8	Grooves as per Drawing	Drg. No.	15x5x3H	Under cut: 1.15H
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565H	Tapping No. of holes 12
13	Tapping Hole Diameter		H16	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 25.4H	Tapping Depth 23.5"
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi: 23/7/25

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, G:

1	Counter Sinking Depth & Finish	ok						Row: 25
2	External Relief Dia	4.5H	83-33	Inner				
3	External Relief Depth		18H	14H				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		23	7	25			

Inspected By (Sign) & Date

Ravi: 23/7/25

Saty: 23/7/25

Reviewed by (Engineer-CNC)

Manager-QA