



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.		15912 ✓	24/40 ✓
2	Machined By		V.T.I M/c Shop	Dry No-23d-1426
3	Pallet Die No.		14578 (3.0)mm	(Rev.00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680 mm ✓	Step OD = 291.9 mm ✓
6	Inside Diameter	Drg. No.	600.14 mm ✓	Step length = 20 mm ✓
7	Width of Pellet Die	Drg. No.	222 mm ✓	Under cart. 6 mm ✓
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 mm / 12.5 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No of Holes = 12
12	Tapping PCD		645 mm ✓	Both side
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 22.4 mm	Tapping depth = 20.5 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 19/9/25

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 - 2 hole Glued

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK	outside	Inner		Counter-68
2	External Relief Dia	3.5 mm	(3-3)	(16 mm)		Row-38
3	External Relief Depth		19 mm			
4	Inspection Done Before Hardening By (Name)		Ravi			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		19	9	25	

Inspected By (Sign) & Date

Ravi 19/9/25

Reviewed by (Engineer-CNC)

Manager-QA