



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.		16094 ✓	36/50
2	Machined By		V.T.I. M/c Shop	Dry No = 1000
3	Pallet Die No.		15688 (3.0) ✓	
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	620 ✓	Step OD = 611.9 ✓
6	Inside Diameter	Drg. No.	520.14 ✓ 519.12 ✓	Step length = 19.8
7	Width of Pellet Die	Drg. No.	2226 ✓	
8	Grooves as per Drawing	Drg. No.	13.3 x 8 x 5 ✓ 13.3 x 8 x 5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		565 ✓	of Holes = 12
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 ✓	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/9/25

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

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

1	Counter Sinking Depth & Finish	OK						Counter = 60°
2	External Relief Dia	12.5 ✓	Outside (23-3)		Inner			Row = 28
3	External Relief Depth		20 ✓		14 ✓			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			23	9	25		

Inspected By (Sign) & Date

Ravi 23/9/25

Reviewed by (Engineer-CNC)

Manager-QA