

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Inprocess Inspection (Pellet Dies)

Form No. CNC/QA/FM/02
Rev. No. 01
Rev. Date 31-07-2013

10757

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		16163 ✓	36/40 ✓
3	Pallet Die No.		V.T.I. M/c Shop	Dry No 2-6-C, 15-062
4	Die Category	Drg. No.	15100 (3.0) H ✓	Rev. 00 ✓
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	499.9 H ✓	Step OD = 498.8 ✓
7	Width of Pellet Die	Drg. No.	420.14 H ✓	Step length 18 ✓
8	Grooves as per Drawing	Drg. No.	158 H ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		454 H ✓	of Holes 28
13	Tapping Hole Diameter		H2.2 Check by H2 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.6 H ✓	Tapping depth = 18.5 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 27/9/25

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

Counter = 25
Row = 24

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5 H ✓	80.5 side (2+2)	Inner			
3	External Relief Depth		10 H ✓	4 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			27	9	25	

Inspected By (Sign) & Date

Ravi 27/9/25

Reviewed by (Engineer-CNC)

Manager-QA