



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.		14741 ✓	40/40 ✓
2	Machined By		V.T.L. H/O Shop	Dry Holes 15.062
3	Pallet Die No.		14680 (3.0) ✓	Ream ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm ✓ Step 02. 498.88	Tabber 12
6	Inside Diameter	Drg. No.	480.12 mm ✓	Step length 28 mm ✓
7	Width of Pellet Die	Drg. No.	158 mm ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm / 12 x 8 x 3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		454 mm ✓	Tapping Holes 8
13	Tapping Hole Diameter		H2 = 2 Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 mm ✓	Tapping Depth 18.5 mm ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raoi 11/5/25

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	3.5 mm ✓	Outside 29.25		Inner			24
3	External Relief Depth		4 mm ✓		Mill			
4	Inspection Done Before Hardening By (Name)				Raoi			
5	Material Sent For Hardening By (Name)				Lark For hard			
6	Material Sent For Hardening On Date			1	5	25		

Inspected By (Sign) & Date

Raoi 11/5/25

Reviewed by (Engineer-CNC)

Manager-QA