



Lark Engineering Company (India) Pvt. Ltd.

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

10025

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.		15204 ✓	36/50
2	Machined By		V. T. L. N/C Shop	3355
3	Pallet Die No.		14698 (4.5) ✓	3311
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 mm ✓	Step length 19.5
6	Inside Diameter	Drg. No.	520.14 mm ✓	
7	Width of Pellet Die	Drg. No.	222 mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		56.5 mm ✓	Tapping No. of holes 12
13	Tapping Hole Diameter		420. Check by 420 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm ✓	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 6/6/25

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 26
2	External Relief Dia	5.0 mm ✓	Outside (3-3)		Inner					2012 29
3	External Relief Depth		19 mm ✓		14 mm ✓					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Porroice
6	Material Sent For Hardening On Date									6 25

Inspected By (Sign) & Date

Ravi 6/6/25

Satya 6/6/25

Reviewed by (Engineer-CNC)

Manager-QA