



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.		15705	
2	Machined By		V.T.L. H/c Shop	40/50 g35
3	Pallet Die No.		14175(4.0) H/c	1 Dy H/c 3510
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	619.9 H/c	Step 00. 611.9 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Step length 9.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20. Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 H/c	Tapping Depth: 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sas: 8/8/25	
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	4.5 H/c	Outside (3.3)	Inner
3	External Relief Depth		14 H/c	10 H/c
4	Inspection Done Before Hardening By (Name)		Sas:	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		6 8 25	
Inspected By (Sign) & Date			Sas: 8/8/25	

Reviewed by (Engineer-CNC)

Manager-QA