



Lark Engineering Company (India) Pvt. Ltd.

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

10551

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Speciflcation	Observations	Remarks
1	Work Order No.		15820	40/40
2	Machined By		V.T.L. H/c Shop	Drill 18.4mm
3	Pallet Die No.		13953(3.5)mm	Ream 18mm
4	Die Category	Drg. No.	5&10	
5	Out Side Diameter	Drg. No.	50mm	Step 12"
6	Inside Diameter	Drg. No.	420.14mm	Step Length 18mm
7	Width of Pellet Die	Drg. No.	182mm	
8	Grooves as per Drawing	Drg. No.	12x 8x 3mm / 12x 8x 3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		420mm	
14	Tapping On Second Side	Half pitch of 1st side	Check by 420 Ball	
15	Tapping Hole Depth		Drill Depth 18.4mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/8/25

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	4.0mm	80 Side (2.2)		Inner					Core 22
3	External Relief Depth		4mm		Null					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		29	8	25					

Inspected By (Sign) & Date

Ravi 29/8/25

Reviewed by (Engineer-CNC)

Manager-QA