



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13628 ✓	45/50 ✓
2	Machined By		V.T.L. M/C Shop	Digital S.C. 12501
3	Pallet Die No.		12873 (6.0) ✓	Revised ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 ✓, Step 002 698 ✓	Tap 12"
6	Inside Diameter	Drg. No.	600-12 ✓	Step Length 20 ✓
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x7 ✓ / 12x8x7 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Tapping No. of Holes - 12 Both Side
12	Tapping PCD		640 ✓	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.3 ✓	Tapping Depth 18.6 ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/12/24

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 60 Row 2-23

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	6.5 ✓	Outside (3-3)		Inner		
3	External Relief Depth		11 ✓		5 ✓		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date		23	12	24		

Inspected By (Sign) & Date

Ravi 23/12/24

31/12/24

Reviewed by (Engineer-CNC)

Manager-QA