



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.		13699 ✓	32/55 ✓
2	Machined By		N.T.L H/c Shop	Dy H/c (S.O) 1327 ✓
3	Pallet Die No.		10741 (4.0) H/c ✓	Rev 200
4	Die Category	Drg. No.	H720	
5	Out Side Diameter	Drg. No.	709.8 H/c	Step 00.692 H/c
6	Inside Diameter	Drg. No.	600.12 H/c	Step length 19.5 ✓
7	Width of Pellet Die	Drg. No.	265 H/c ✓	
8	Grooves as per Drawing	Drg. No.	15x8x7 H/c / 15x8x7 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes - 12 Both Side
12	Tapping PCD		640 H/c ✓	
13	Tapping Hole Diameter		M20 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.2 H/c	Tapping Depth: 18.6 H/c ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/7/25

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			Low 39
3	External Relief Depth		27 H/c ✓		23 H/c ✓			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		2	1	25			

Inspected By (Sign) & Date

Ravi 31/7/25

Satyam 31/7/25

Reviewed by (Engineer-CNC)

Manager-QA