



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.		13826 ✓	36/50
2	Machined By		N.T.I. H/c Shop	Dy. H/c B.G. 12/50
3	Pallet Die No.		13548 (4.0) ✓	Revol ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/c / Step 002 B93 ✓	Tabber 12°
6	Inside Diameter	Drg. No.	600.12 H/c ✓	Step length 20 H/c ✓
7	Width of Pellet Die	Drg. No.	222 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8 x 7 H/c / 12x8 x 7 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		640 H/c ✓	Tapping No of holes 12 Rough Side
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 20.2 H/c Tapping Depth 18.6 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/1/25

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 - Hole Colused (A)

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 (2.3)		Inner			Low = 39
3	External Relief Depth		18 H/c		14 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		9	1	25			

Inspected By (Sign) & Date

Ravi 9/1/25

Reviewed by (Engineer-CNC)

Manager-QA