



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.		13276 ✓	33/50 ✓
2	Machined By		V. T. L. H/c Shop	Drg No. 13276 ✓
3	Pallet Die No.		14221 (3.0) H/c ✓	Rev = 00 ✓
4	Die Category	Drg. No.	Tomb	
5	Out Side Diameter	Drg. No.	760 H/c ✓	Step OD = 802 H/c ✓
6	Inside Diameter	Drg. No.	660.12 H/c ✓	Step length = 30 H/c ✓
7	Width of Pellet Die	Drg. No.	290 H/c ✓	Under cut = 231.5 H/c ✓
8	Grooves as per Drawing	Drg. No.	27 x 8 x 7.5 H/c ✓	27 x 8 x 7.5 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		724 H/c ✓	Tapping r/c of Holes = 12 Both Side
13	Tapping Hole Diameter		M22 - Check by M22 Bore ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 29.2 H/c ✓	Tapping Depth = 29.6 H/c ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/1/25

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 Closed

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	3.5 H/c ✓	Outside (3-3)		Innen			Row = 48
3	External Relief Depth		23 H/c ✓		17 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		11	1	25			

Inspected By (Sign) & Date

Ravi 11/1/25

Reviewed by (Engineer-CNC)

Manager-QA