



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.		14171 ✓	33/55 ✓
2	Machined By		V.T.L. N/C Shop	Order 1.3.0 = 600
3	Pallet Die No.		14103 (6.0) ✓	Rev. 00 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	12.0 ✓	
6	Inside Diameter	Drg. No.	6.92 ✓	Tapper 12"
7	Width of Pellet Die	Drg. No.	6.0 ✓	Step length 2.0 ✓
8	Grooves as per Drawing	Drg. No.	2.2.1 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	1.2 x 1.0 x 7.5 ✓ / 1.2 x 1.0 x 7.5 ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		6.4 ✓	Tapping No. of Holes = 12 Both 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 20.3 ✓	Tapping Depth 18.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Soni 13/7/25

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	6.5 ✓	Outside 2.5 ✓		Inner			3.5 ✓
3	External Relief Depth		2.9 ✓		2.3 ✓			
4	Inspection Done Before Hardening By (Name)							Soni ✓
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		13	2	25			

Inspected By (Sign) & Date

Soni 13/7/25

Reviewed by (Engineer-CNC)

Manager-QA