



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

9183

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14184 /	40/48/55 /
2	Machined By		V.T.L. n/c. Shop	Dr. No. 13.0.030
3	Pallet Die No.		14121 (6.0) n/c	Ro. 0200 /
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	710mm, Step 002 693mm	Tapper 13°
6	Inside Diameter	Drg. No.	600.12 mm	Step length 2mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12x10x7.5mm 12x10x7.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c. Shop	Tapping No. of holes 212 Bolt Side
12	Tapping PCD		640mm /	
13	Tapping Hole Diameter		M2 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3mm	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rawi 13/8/25

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

Counter 60

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	6.5mm 7.0mm	6.5mm	All Rows 2	15mm			
3	External Relief Depth		7.0mm	All Rows 2	7mm			
4	Inspection Done Before Hardening By (Name)			Rawi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		13	2	25			

Inspected By (Sign) & Date

Rawi 13/2/25

Reviewed by (Engineer-CNC)
 13/2/25

Manager-QA