



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.		14138 ✓	53/58 ✓
2	Machined By		V. T. L. n/c Shop	Drilling 12.02.13 ✓
3	Pallet Die No.		13809 (2.8) ✓	Recess ✓
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	636mm, Step 00, 612mm	Step length 19.5 ✓
6	Inside Diameter	Drg. No.	520.12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm 13x8x5mm	
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, 12 Both Side
12	Tapping PCD		565mm ✓	
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, 20.3mm Tapping Depth, 18.5mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/2/25

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 - 4 Hole Collected

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60
Row = 33

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.3mm	20 Side (23-3)	Inner			
3	External Relief Depth		12mm	5mm			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		22	2	25		

Inspected By (Sign) & Date

Ravi 22/2/25

Satya 22/2/25

Inspected by (Engineer-CNC)

Manager-QA