



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.		14248 ✓	42/45 ✓
2	Machined By		V. T. G. N/C Shop	Dy. No. 1.3.0.1256
3	Pallet Die No.		12088 (6.0) N/C	Rev: 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510 N/C, Step OD = 491.8 N/C	Step length = 12.5
6	Inside Diameter	Drg. No.	420.12 N/C	
7	Width of Pellet Die	Drg. No.	152 N/C	
8	Grooves as per Drawing	Drg. No.	1145 x 3 N/C 1145 x 3 N/C	
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 = 8 Both Side]
12	Tapping PCD		456 N/C	
13	Tapping Hole Diameter		Ø31.4 = Check by Ø31.4 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 16.2 N/C	Tapping Depth = 14.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/2/25

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

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	6.5 N/C	outside (2.2)		Inner					
3	External Relief Depth		9 N/C		3 N/C					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Lark Porrace
6	Material Sent For Hardening On Date		28	2	25					

Inspected By (Sign) & Date

Ravi 28/2/25

Satish 28/2/25

Reviewed by (Engineer-CNC)

Manager-QA