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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.		14303/1	39/55
2	Machined By		V.T.L. N/C. Shop	Dy No. 13.2.407
3	Pallet Die No.		14125 (6.0) HH	Rev. 00
4	Die Category	Drg. No.	N. Turbo	
5	Out Side Diameter	Drg. No.	710 HH, Step OD: 692.8 HH, Taper 12°	
6	Inside Diameter	Drg. No.	600.12 HH	Step length 30 HH
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	12×8×7 HH / 12×8×7 HH	
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		640 HH	
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 HH Tapping Depth: 18.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 8/3/25	
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 Go

1	Counter Sinking Depth & Finish	ok						Rev. 23
2	External Relief Dia	6.75 HH	Outside (3-3)		Inner			
3	External Relief Depth		22 HH		16 HH			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		8	3	25			
	Inspected By (Sign) & Date		Ravi 8/3/25					

Satbir 8/3/25
Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner