



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.			
2	Machined By		14685 ✓	37/50
3	Pallet Die No.		N.T.L. H/c Shop	Drg No. 16.02.98
4	Die Category	Drg. No.	14036 (4.0) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	Ext. side	
6	Inside Diameter	Drg. No.	619.8 H/c	Step 002 Tapper 12°
7	Width of Pellet Die	Drg. No.	52.12 H/c	Step length 18.5
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/c Shop	
12	Tapping PCD		56.5 H/c	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	Tapping H/c of H/c 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rev: 6/5/25	
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 - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter Go
2	External Relief Dia	4.5 H/c	Outside (23-3)	Rev. 31
3	External Relief Depth		17 H/c	Inner 13 H/c
4	Inspection Done Before Hardening By (Name)		Rawi	
5	Material Sent For Hardening By (Name)		Lark Punrace	
6	Material Sent For Hardening On Date		6 5 25	
Inspected By (Sign) & Date			Rev: 6/5/25	

Reviewed by (Engineer-CNC)

Manager-QA