



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)

9671

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14671	40/48/55
2	Machined By		N.T.L. N/C. Shop	Dr. H. 12.0.00
3	Pallet Die No.		14233 (6.0) mm	Reo 200
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710 mm, Step 00. 693 mm	Step length 2 mm
6	Inside Diameter	Drg. No.	600.12 mm	Tapping 12
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 mm 12x10x7.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C. Shop	Tapping N/C
12	Tapping PCD		640 mm	of holes 12
13	Tapping Hole Diameter		N/C. Check by H.C. Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm Tapping Depth 18.5 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 20/4/25

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

Completed - 20/4/25

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 mm 7.0 mm	6.5 mm	All Rows 2	15 mm				
3	External Relief Depth		7.0 mm	All Rows 2	7 mm				
4	Inspection Done Before Hardening By (Name)			Raw!					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date		20	4	25				

Inspected By (Sign) & Date

Raw! 20/4/25

Reviewed by (Engineer-CNC)

Manager-QA