



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)

10617

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15913	40/48/55
3	Pallet Die No.		N.T.L. H/c Shop	Drg. No. 12.0.66
4	Die Category	Drg. No.	15482 (G.O.)	Rev. 2.00
5	Out Side Diameter	Drg. No.	H. 70 mm	
6	Inside Diameter	Drg. No.	710 mm Step 005-693 mm	Tapper 12"
7	Width of Pellet Die	Drg. No.	800.14 mm	Step length 20 mm
8	Grooves as per Drawing	Drg. No.	222 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x10x7.5 mm / 12x10x7.5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		640 mm	
14	Tapping On Second Side	Half pitch of 1st side	H20. Check by H20 Ball	Tapping H/c of holes 12
15	Tapping Hole Depth		ok	Back Side
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 mm	Tapping Depth 18.4
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Rev: 9/9/25

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							
2	External Relief Dia	2.5 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)		Rev:						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		9	9	25				
Inspected By (Sign) & Date			Rev: 9/9/25						

9/9/25

Reviewed by (Engineer-CNC)

Manager-QA