



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.		13050	45/55
2	Machined By		N. T. L. n/c Shop	Dr. H. 180410
3	Pallet Die No.		15323 (8.0)	Rev. 01
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	630mm	Step on 624mm
6	Inside Diameter	Drg. No.	520.14mm	Tapping 12"
7	Width of Pellet Die	Drg. No.	186mm	Step length 18mm
8	Grooves as per Drawing	Drg. No.	13x8x3mm	13x8x3mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping 12"
12	Tapping PCD		565mm	of holes 12"
13	Tapping Hole Diameter		120	Check by H20 Bolt
14	Tapping On Second Side	Half pitch of 1st side	ok	Bottom Side
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/9/25

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	8.5mm	Outside (2-3)		Inner				
3	External Relief Depth		18mm		10mm				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Porrace				
6	Material Sent For Hardening On Date		23	9	25				

Inspected By (Sign) & Date

Ravi 23/9/25

Reviewed by (Engineer-CNC)

Manager-QA