



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.		15986	55/55
2	Machined By		V.T.I. M/c Shop	Dry No. 1-8-C 14924
3	Pallet Die No.		11015 (5.0) 44	Rev. 2.00
4	Die Category	Drg. No.	2-12-20 side	
5	Out Side Diameter	Drg. No.	629.9 44	Step OD 261.9 44
6	Inside Diameter	Drg. No.	520.14 44	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 44	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 44 / 13 x 8 x 5 44	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		565 44	of Holes 12
13	Tapping Hole Diameter		M20 Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 44	Tapping depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 26/9/25

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						Counter 260
2	External Relief Dia	5.5 44	8 Side (3-3)		Inner			Rows 226
3	External Relief Depth		5 44		Null			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			26	9	25		
Inspected By (Sign) & Date					Ravi	26/9/25		

Reviewed by (Engineer-CNC)

Manager-QA