



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.		13972 ✓	35/40/66 ✓
2	Machined By		V. T. L n/c Shop	Dy. S. 13.02.2013
3	Pallet Die No.		14022 (G.0) n/c	Row 02 ✓
4	Die Category	Drg. No.	H. Tombo	
5	Out Side Diameter	Drg. No.	680.1 n/c	Step 00, 692.8 n/c
6	Inside Diameter	Drg. No.	546.12 n/c (Box = 548.1 n/c)	Step Length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Order cut = 2.8 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 n/c 32 x 7 x 9.1 n/c	(4 x 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 n/c Deep Back Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 2 Back Side
12	Tapping PCD		619 n/c	
13	Tapping Hole Diameter		NIG - Check by NIG Belt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2 n/c	Tapping Depth 31.5 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Savi 12/7/25

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 = 30

1	Counter Sinking Depth & Finish	ok						Row = 12
2	External Relief Dia	6.5 n/c 7.0 n/c	6.5 n/c	All Rows = 31 n/c	✓			
3	External Relief Depth		7.0 n/c	All Rows = 26 n/c	✓			
4	Inspection Done Before Hardening By (Name)			Savi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		12	2	24			

Inspected By (Sign) & Date

Savi 12/7/25

Reviewed by (Engineer-CNC)

Manager-QA