



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.		13982 ✓	32/70 ✓
2	Machined By		V.T.L. M/C Shop	Qty 10 - 18.2-3 ✓
3	Pallet Die No.		13374(6.0) ✓	Rev: 03 ✓
4	Die Category	Drg. No.	H. Jamba	
5	Out Side Diameter	Drg. No.	688 M/C Step 00, 697.4 M/C	Tappers 5°
6	Inside Diameter	Drg. No.	546.12 M/C (Bore 548.3 M/C)	Step length 28.5
7	Width of Pellet Die	Drg. No.	215 M/C	Undercut 1.8 M/C
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 9.1 M/C / 29.5 x 10 x 9.1 M/C (6.2) M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face side step
11	Tapping Operator		M/C Shop	Face Dark Back Side
12	Tapping PCD		618 M/C ✓	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	Tapping side of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Back Side
15	Tapping Hole Depth		Drill Depth 32.2 M/C	Tapping Dept. 30.4 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/2/25

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 30°
2	External Relief Dia	7.0 M/C	All Rows					Rev: 14
3	External Relief Depth		38 M/C ✓					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		21	2	25			

Inspected By (Sign) & Date

Ravi 21/2/25

Reviewed by (Engineer-CNC)
Sats 21/2/25

Manager-QA