



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.		14010	57/66
2	Machined By		V.T.L. H/c Shop	Digital 630 320
3	Pallet Die No.		14024 (10.0) H/c	Row 08
4	Die Category	Drg. No.	H. Jumbo	Row 08
5	Out Side Diameter	Drg. No.	680.1 H/c	Step 0.5 693 H/c Tapper 8
6	Inside Diameter	Drg. No.	546.12 H/c (Box 548.4 H/c)	Step length 2.1 H/c
7	Width of Pellet Die	Drg. No.	195.1 H/c	Order cost = 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 H/c	32 x 7 x 9.2 H/c (4 x 3) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face side step 2 H/c Deep Both Side
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	Tapping H/c of holes 2
13	Tapping Hole Diameter		M26, Check by HIG Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2 H/c	Tapping Depth 31.5 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 27/2/25*

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 60° Row 8
2	External Relief Dia	11.0 H/c		All Rows					
3	External Relief Depth			9 H/c					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Porrace					
6	Material Sent For Hardening On Date			27	2	25			

Inspected By (Sign) & Date *Ravi 27/2/25*

Ravi 27/2/25
Reviewed by (Engineer-CNC)

Manager-QA