



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.		14345/	32/66/
2	Machined By		V.T.L. m/c Shop	Dy. m/c, 12.02.20
3	Pallet Die No.		14019 (9.0) m/c	Rev. 02/
4	Die Category	Drg. No.	H-20 m/c	
5	Out Side Diameter	Drg. No.	680.1 m/c, Step 002, 693 m/c	Tabber 2"
6	Inside Diameter	Drg. No.	546.12 m/c (Bore 548.0 m/c)	Step length 31 m
7	Width of Pellet Die	Drg. No.	195 m/c	Under cut 2.8 m
8	Grooves as per Drawing	Drg. No.	32+7+9.1 m/c 32+7+9.1 m/c (4+8) m/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		m/c Shop	
12	Tapping PCD		619 m/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2 m/c	Tapping Depth 31.5 m/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi: 18/3/25	
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 20	
2	External Relief Dia	10.0 m/c	All Rows	
3	External Relief Depth		4 m/c	
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Ravneet	
6	Material Sent For Hardening On Date		18	3
Inspected By (Sign) & Date			Sasi: 18/3/25	

Reviewed by (Engineer-CNC)

Manager-QA