



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)

9.110
9513

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14560	60/66
3	Pallet Die No.		N.C. Shop	1 Dry Hole 1.2.02390
4	Die Category	Drg. No.	14773 (10-0) H	Rev 08
5	Out Side Diameter	Drg. No.	N. Jumbo	
6	Inside Diameter	Drg. No.	680.1 H, Step 002 693 H	Tap hole 8°
7	Width of Pellet Die	Drg. No.	546.12 H (Base 548.1) H	Step length 31 H
8	Grooves as per Drawing	Drg. No.	195 H	Under cut 2.
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.1 H 32 x 7 x 9.1 H (4 x 8) H	
10	Drilling Area Surface Smoothness		ok	Pure Side Step
11	Tapping Operator		N.C. Shop	8 H Deep Bottom
12	Tapping PCD		319 H	Side
13	Tapping Hole Diameter		N/C	Tapping N/C
14	Tapping On Second Side	Half pitch of 1st side	ok	of holes 2
15	Tapping Hole Depth		Drill Depth 33.4 H	Bottom Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 31.5
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/3/25

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

Counters 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	11.0 H		All Rows					
3	External Relief Depth			6 H					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date		27	3	25				

Inspected By (Sign) & Date

Ravi 28/3/25

Satish 27/3/25

Reviewed by (Engineer-CNC)

Manager-QA