



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.		14698	42/05
2	Machined By		V. T. L. H/c Shop	Dy. No. 1.2.02 788
3	Pallet Die No.		14878 (G.O) H/c	Rev. 01
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	878 H/c Step 00. 693 H/c	Tabber 28°
6	Inside Diameter	Drg. No.	546.12 H/c (Bor 548.3 H/c)	Step length 28 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Undercut 2.85 H/c
8	Grooves as per Drawing	Drg. No.	31x8x9.1 H/c / 31x8x9.1 H/c	(5x8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	1 H/c Deep Both Side
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	Tapping H/c
13	Tapping Hole Diameter		H16 Check by H16 Ball	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 38.4 H/c	Tapping Depth 36.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 31/5/25	
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	1.0 H/c	All Rows	Rows 12
3	External Relief Depth		24 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purrace	
6	Material Sent For Hardening On Date		3 5 25	
Inspected By (Sign) & Date			Ravi 31/5/25	

Reviewed by (Engineer-CNC)

Manager-QA