



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.		14885	38/53/66
2	Machined By		V. T. L. w/c Shop	Dry H. 12.0.32
3	Pallet Die No.		14882 (G.O) H	Revised
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H Step 00. 692 H	Tapper 8
6	Inside Diameter	Drg. No.	546.12 H (Box = 548.12)	Step length = 9mm
7	Width of Pellet Die	Drg. No.	195 H	Under cut = 2.8 H
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H 32 x 7 x 9.1 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Sep
10	Drilling Area Surface Smoothness		ok	2 H Deep
11	Tapping Operator		w/c Shop	Both Side
12	Tapping PCD		619 H	Tapping H
13	Tapping Hole Diameter		H16 = Check by H16 Bolt	of Hole = 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth = 33.4 H	Tapping Depth = 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sas: 7/5/25	
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	6.5 H 7.0 H	6.5 H All Rows = 98 H	Row = 12
3	External Relief Depth	7.0 H	All Rows = 103 H	
4	Inspection Done Before Hardening By (Name)		Sas:	
5	Material Sent For Hardening By (Name)		Lark Permare	
6	Material Sent For Hardening On Date		7 5 25	
Inspected By (Sign) & Date			Sas: 7/5/25	

Reviewed by (Engineer-CNC)

Manager-QA