



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)

9835

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14850	58/66
2	Machined By		V. T. L. H/c Shop	Drill 12.22.39
3	Pallet Die No.		14986 (9.0)	Renod
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.44	Tap hole 8'
6	Inside Diameter	Drg. No.	546.12	Step length 31.4
7	Width of Pellet Die	Drg. No.	195.44	Under cut = 28.4
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1	C 4 x 8
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step
10	Drilling Area Surface Smoothness		ok	Inner Deep
11	Tapping Operator		H/c Shop	Bottom Side
12	Tapping PCD		819.44	Tap hole 2
13	Tapping Hole Diameter		H/c Shop	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	ok	Tap hole 31.5
15	Tapping Hole Depth		Drill Depth 33.4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rev: 10/5/25	
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 60
2	External Relief Dia	10.0	All Rows	Row 8
3	External Relief Depth		8mm	
4	Inspection Done Before Hardening By (Name)		Rev:	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		10 5 25	
Inspected By (Sign) & Date			Rev: 10/5/25	

Reviewed by (Engineer-CNC)

Manager-QA