



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9876

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.		14883	36/51
2	Machined By		V.T.L. H/c Shop	Dry H/c 1.2.0.1198
3	Pallet Die No.		14571(3.0) H/c	Rev. 00
4	Die Category	Drg. No.	Tumbo	
5	Out Side Diameter	Drg. No.	801.9 H/c	Step 00. 822.7 H/c
6	Inside Diameter	Drg. No.	700.14 H/c	Step length. 332
7	Width of Pellet Die	Drg. No.	324.1 H/c	Ends cut. 10.5 H/c
8	Grooves as per Drawing	Drg. No.	30x8x8.5 H/c	30x8x8.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		760 H/c	of H/c. 12
13	Tapping Hole Diameter		M22 2 Check by M22 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 36.4 H/c	Tapping Depth. 34.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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

Counter. 60

1	Counter Sinking Depth & Finish	ok								Ravi 53
2	External Relief Dia	3.5 H/c	Outside (3-3)		Inner					
3	External Relief Depth		21 H/c		15 H/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		10	5	25					

Inspected By (Sign) & Date

Ravi 10/5/25

Saty 10/5/25

Reviewed by (Engineer-CNC)

Manager-QA