



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.		14860	28/38/66
2	Machined By		V.T.L. H/C Shop	Dy No 18.0.6
3	Pallet Die No.		15029 (6.0) H/C	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/C Shop 001 693 H/C Tapper 8	
6	Inside Diameter	Drg. No.	546.12 H/C (Bor. 548.4 H/C) Step length 9 H/C	
7	Width of Pellet Die	Drg. No.	195 H/C	Under cut 9.5 H/C
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 H/C 32.7 x 9.2 H/C (4 x 8) H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	9 H/C Deep
11	Tapping Operator		H/C Shop	Both Side
12	Tapping PCD		619 H/C	Tapping No
13	Tapping Hole Diameter		H16: Check by H16 Bolt	of holes 9
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 H/C	Tapping Depth 3.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

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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 230
2	External Relief Dia	6.5 H/C 7.10 H/C	6.5 H/C	All Rows 2 38 H/C				Row 12
3	External Relief Depth		7.10 H/C	All Rows 2 38				
4	Inspection Done Before Hardening By (Name)			Rev:				
5	Material Sent For Hardening By (Name)			Lark Purchase				
6	Material Sent For Hardening On Date		19	5	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA