



Lark Engineering Company (India) Pvt. Ltd.

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

9951

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.		14918	66/66
2	Machined By		V. T. L. HLC Shop	By H. 12.0.92
3	Pallet Die No.		15033 (10.0) HLC	Rev. 08
4	Die Category	Drg. No.	H. Tumba	
5	Out Side Diameter	Drg. No.	680.1 HLC Step ON 693 HLC	Upper 8
6	Inside Diameter	Drg. No.	546.12 HLC (Bor = 548.2) HLC	Step length 23 HLC
7	Width of Pellet Die	Drg. No.	195 HLC	Under cut 2.8 HLC
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 HLC 32 x 7 x 9.1 HLC (4 x 8)	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 HLC Deep
11	Tapping Operator		HLC Shop	Both Side
12	Tapping PCD		819 HLC	Tapping HLC
13	Tapping Hole Diameter		HLC Check by HLC Bolt	of Holes 8
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 HLC	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/5/25

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, C. 8
2	External Relief Dia								
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

Ravi 24/5/25

Satya 24/5/25

Reviewed by (Engineer-CNC)

Manager-QA