



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)

9976

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15043	38/48/66
2	Machined By		N.T.L. H/c Shop	Drg No. 13.9.39
3	Pallet Die No.		14876(10.0) H/c	Rev 208
4	Die Category	Drg. No.	H. Tumbo	
5	Out Side Diameter	Drg. No.	680.1 H/c Step 0.0 693 H/c	Tabber 8"
6	Inside Diameter	Drg. No.	546.12 H/c (Bore 548.2 H/c)	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Load cut 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c 32 x 7 x 9.1 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	2 H/c Deep Boh
11	Tapping Operator		H/c Shop	Side
12	Tapping PCD		619 H/c	Tapping H/c
13	Tapping Hole Diameter		H/c	of Holes 2
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 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 28/5/25

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						Raw: 8
2	External Relief Dia	10.5 H/c 11.0 H/c	10.5 H/c	All Rops 2 30 H/c				
3	External Relief Depth		11.0 H/c	All Rops 2 18 H/c				
4	Inspection Done Before Hardening By (Name)			Raw:				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		28	5	25			

Inspected By (Sign) & Date

Raw: 28/5/25

Reviewed by (Engineer-CNC)

Manager-QA