



Lark Engineering Company (India) Pvt. Ltd.

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

9996

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.		15093	30/66
2	Machined By		V.T.L. N/C. Shop	Day No. 12.2-3.30
3	Pallet Die No.		15208 (G.O) Fin	Rev. 08
4	Die Category	Drg. No.	N. Jorbo	
5	Out Side Diameter	Drg. No.	680.144	Tapper. 8°
6	Inside Diameter	Drg. No.	546.124 (Box. 548.244)	Step length. 31.4
7	Width of Pellet Die	Drg. No.	19544	Undercut. 9.84
8	Grooves as per Drawing	Drg. No.	32.779.144	(4x8)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 mm. Deep
11	Tapping Operator		N/C. Shop	Both Side
12	Tapping PCD		61944	Tapping No.
13	Tapping Hole Diameter		M16. Check by M16 Bolt	of holes. 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth = 33.44	Tapping Depth. 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 30/5/25

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						Counters 30
2	External Relief Dia	7.044	All Rows					Rows = 12
3	External Relief Depth		3644					
4	Inspection Done Before Hardening By (Name)		Raw					
5	Material Sent For Hardening By (Name)		Lark Purrace					
6	Material Sent For Hardening On Date		03/05/25	5	25			

Inspected By (Sign) & Date

Raw: 30/5/25

Reviewed by (Engineer-CNC)

Manager-QA