



Lark Engineering Company (India) Pvt. Ltd.

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

10023

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.			
2	Machined By		15162 ✓	24/66 ✓
3	Pallet Die No.		V.T.L. H/C Shop	Qty 11, 120-320
4	Die Category	Drg. No.	152-9 (6.0) H/C	Rev. 08
5	Out Side Diameter	Drg. No.	M. 7mm H/C	
6	Inside Diameter	Drg. No.	680.1 H/C Step 001, 693 H/C	Tap hole 8"
7	Width of Pellet Die	Drg. No.	546.12 H/C (Box = 548.2 H/C)	Step length 10.31 H/C
8	Grooves as per Drawing	Drg. No.	195 H/C	Under cut = 2.8 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.1 H/C / 32.7 x 9.1 H/C	(4 x 8) H/C
10	Drilling Area Surface Smoothness		ok	Face Side 8"
11	Tapping Operator		H/C Shop	2 H/C Deep
12	Tapping PCD		619 H/C	Back Side
13	Tapping Hole Diameter		NIG. Check by NIG Bolt	Tapping H/C
14	Tapping On Second Side	Half pitch of 1st side	ok	of hole 2"
15	Tapping Hole Depth		Drill Depth 33.4 H/C	Back Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 31 H/C
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rev. 6/6/25

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

Counters 30

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0 H/C	All Rows						
3	External Relief Depth		42 H/C						
4	Inspection Done Before Hardening By (Name)		Rev.						
5	Material Sent For Hardening By (Name)		Lark Rorance						
6	Material Sent For Hardening On Date		6	6	25				

Inspected By (Sign) & Date

Rev. 6/6/25

Set 1/6/25

Reviewed by (Engineer-CNC)

Manager-QA