



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.		15184	40/50/70
2	Machined By		V.T.L. n/c Shop	Dy 4-18.12.13
3	Pallet Die No.		14339(8.0) n/c	Rev 103
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 n/c, Step 002 697.8 n/c	Tabbers 5
6	Inside Diameter	Drg. No.	546.12 n/c (Bore 548.3 n/c)	Step length 38.5
7	Width of Pellet Die	Drg. No.	215 n/c	Indent 1.8 n/c
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 9 n/c / 29.5 x 10 x 9 n/c	(B+8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	1 n/c Deep
11	Tapping Operator		n/c Shop	Back Side
12	Tapping PCD		618 n/c	Tapping H.
13	Tapping Hole Diameter		M16 Check by M16 Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Back Side
15	Tapping Hole Depth		Drill Depth 32.4 n/c	Tapping Depth 30.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/6/25

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

Counter 30

1	Counter Sinking Depth & Finish	ok						Rev 12
2	External Relief Dia	8.5 n/c / 9.0 n/c	8.5 n/c	All Rows	2 30 n/c			
3	External Relief Depth		9.0 n/c	All Rows	2 30 n/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		13	6	25			

Inspected By (Sign) & Date

Ravi 13/6/25

Reviewed by (Engineer-CNC)

Manager-QA