



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.		15208	36/42
2	Machined By		V.T.L. H/c Shop	Dy. No. 12.0.908
3	Pallet Die No.		14852 (3.0) H/c	Rev. 00
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	604 H/c	Step 00. 621.5 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Tabber. 12
7	Width of Pellet Die	Drg. No.	222 H/c	Step length 201.5 H/c
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	Under cut. 8.75
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	Tapping H/c of H20. 12
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth. 20.4 H/c	Tapping Depth. 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rao: 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

1	Counter Sinking Depth & Finish	ok						Counter Bo
2	External Relief Dia	3.5 H/c	All Rows					Rev. 28
3	External Relief Depth		6 H/c					
4	Inspection Done Before Hardening By (Name)		Rao:					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		13	6	25			

Inspected By (Sign) & Date

Rao: 13/6/25

Reviewed by (Engineer-CNC)

Manager-QA