



Lark Engineering Company (India) Pvt. Ltd.

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

10212

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		15277	35/40/88
3	Pallet Die No.		V.T.L H/C Shop	Day No. 12.6-7
4	Die Category	Drg. No.	15164(6.0)H/C	Rev. 03
5	Out Side Diameter	Drg. No.	H. 10mm	
6	Inside Diameter	Drg. No.	680.7mm Step on 693mm Tappet 8"	
7	Width of Pellet Die	Drg. No.	546.14mm (Box 548.4mm) Step length 21mm	
8	Grooves as per Drawing	Drg. No.	195mm	End cut 2.5mm
9	Fitting Sizes on CNC Plate	Drg. No.	32x779.2mm / 32x779.2mm (4-8)mm	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		ok	2nd Side Back
12	Tapping PCD		H/C Shop	Side
13	Tapping Hole Diameter		619mm	Tapping No
14	Tapping On Second Side	Half pitch of 1st side	H/C Check by H/C Bolt	of 4 sides
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.4mm Tapping Depth 31.5	
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 21/7/25

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 30
2	External Relief Dia	6.5mm/10mm	6-5mm	All Rows = 31mm				Rows 12
3	External Relief Depth		7.0mm	All Rows 28mm				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Purnace				
6	Material Sent For Hardening On Date			7	7	25		

Inspected By (Sign) & Date

Ravi 21/7/25

Reviewed by (Engineer-CNC)

Manager-QA