



Lark Engineering Company (India) Pvt. Ltd.

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

10343

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		15403	35/66
3	Pallet Die No.		V.T.L H/c Shop	Dry H. 13.2
4	Die Category		15214 (8.0) H/c	Rev. 08
5	Out Side Diameter	Drg. No.	H. 7mm h 0	24x5
6	Inside Diameter	Drg. No.	680.14 H/c Step 00. 693 H/c	Tapping B
7	Width of Pellet Die	Drg. No.	546.12 H/c (Box 2 548.2)	Step length 31 H/c
8	Grooves as per Drawing	Drg. No.	195 H/c	Under side 2.8 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.1 H/c 32 x 7 x 9.1 H/c (4 x 8)	Face side
10	Drilling Area Surface Smoothness		ok	2 H/c Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 H/c	Tapping H
13	Tapping Hole Diameter		H16 Check by H16 Bolt	of Holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth = 33.7 H/c	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Res. 9/8/25

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. 10
2	External Relief Dia	9.0 H/c		All Rows				
3	External Relief Depth			31 H/c				
4	Inspection Done Before Hardening By (Name)			Res.				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date			9	7	25		

Inspected By (Sign) & Date

Res. 9/8/25

Reviewed by (Engineer-CNC)

Manager-QA