



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.		15406	19/66
2	Machined By		N.T.L. N/C Shop	Dry Holes 18.06.09
3	Pallet Die No.		15168 (6.0) H	Rev. 03
4	Die Category	Drg. No.	H. Jumbo	Unapproved
5	Out Side Diameter	Drg. No.	680.7 H	Step 00 = 683 H = Tappet 8"
6	Inside Diameter	Drg. No.	546.12 H (Res = 548.4 H)	Step length 31 H
7	Width of Pellet Die	Drg. No.	195 H	Under cut = 2.5 H
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 H	32 x 7 x 9.2 H (4 x 8) H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side 8"
11	Tapping Operator		N/C Shop	Back Side
12	Tapping PCD		619 H	Tapping Holes 2
13	Tapping Hole Diameter		H16	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 33.4 H	Tapping Depth = 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 19/7/25

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

Counter 30

1	Counter Sinking Depth & Finish	OK						Row 212
2	External Relief Dia	7.5 H	All Rows					
3	External Relief Depth		47 H					
4	Inspection Done Before Hardening By (Name)		Raw:					
5	Material Sent For Hardening By (Name)		Lark Permare					
6	Material Sent For Hardening On Date		19	7	25			

Inspected By (Sign) & Date

Raw: 19/7/25

Satyam
19/7/25

Reviewed by (Engineer-CNC)

Manager-QA