



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.		15430	23/33/60
2	Machined By		V. T. L. H/c Shop	23/33/60
3	Pallet Die No.		15339 (G.O.) H/c	Rev 108
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/c	Step 002 693 H/c
6	Inside Diameter	Drg. No.	546.12 H/c	(Ress. 548.2) H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Step length 31 H/c
8	Grooves as per Drawing	Drg. No.	32+7+9.1 H/c	32+7+9.1 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32+7+9.1 H/c	(4+8) H/c
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		OK	2 H/c Deep
12	Tapping PCD		H/c Shop	Both Side
13	Tapping Hole Diameter		619 H/c	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	H/c, Check by H/c Ball	of holes - 2
15	Tapping Hole Depth		OK	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 233.4 H/c	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

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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							
2	External Relief Dia	6.5 H/c	7.0 H/c	6.5 H/c	All Rows = 43 H/c				
3	External Relief Depth			7.0 H/c	All Rows = 33 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA