



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.		15464 ✓	58/G6
2	Machined By		V. T. L. H/L Shop	Drill Hole 12.0 320
3	Pallet Die No.		15343 (9.0) H/L	Rev. 08
4	Die Category	Drg. No.	M. Tomba	
5	Out Side Diameter	Drg. No.	680.1 H/L	Step 60. 693 H/L
6	Inside Diameter	Drg. No.	546.14 H/L (Bore 548.2) H/L	Step length 31 H/L
7	Width of Pellet Die	Drg. No.	195 H/L	Under cut 28 H/L
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H/L 32.7 x 9.1 H/L (4 x 8)	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Race Side
10	Drilling Area Surface Smoothness		OK	2 H/L Deep
11	Tapping Operator		H/L Shop	Both Side
12	Tapping PCD		619 H/L	Tapping H/L
13	Tapping Hole Diameter		H/L 2. C. back by H/L 6 Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.6 H/L	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Savi 23/7/25

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 60
2	External Relief Dia	10.0 H/L		All Pores					Rev. 08
3	External Relief Depth			8 H/L					
4	Inspection Done Before Hardening By (Name)			Savi					
5	Material Sent For Hardening By (Name)			Lark Porrace					
6	Material Sent For Hardening On Date		23	7	25				

Inspected By (Sign) & Date

Savi 23/7/25

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Reviewed by (Engineer-CNC)

Manager-QA