



Lark Engineering Company (India) Pvt. Ltd.

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

10389

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		15464 ✓	58/66
3	Pallet Die No.		V.T.L. H/c Shop	Qty. 120.32
4	Die Category	Drg. No.	15506(9.0) H/c	Rev. 08
5	Out Side Diameter	Drg. No.	M. Tomba	
6	Inside Diameter	Drg. No.	680.2 H/c Step 00. 693 H/c Tapper. 8°	
7	Width of Pellet Die	Drg. No.	546.14 H/c (Box 548.2) H/c	Step length 3 H/c
8	Grooves as per Drawing	Drg. No.	195 H/c	Under cut 2.8 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 ± 9.1 H/c 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 H16 Bolt	of Holes. 2
15	Tapping Hole Depth		OK	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.7 H/c	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

Raw: 30/7/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		N.

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/c		All Rows				Rows 8
3	External Relief Depth			8 H/c				
4	Inspection Done Before Hardening By (Name)			Raw:				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		30	7	25			

Inspected By (Sign) & Date

Raw: 30/7/25

30/7/25

Reviewed by (Engineer-CNC)

Manager-QA