



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.		15440	34/65
2	Machined By		V.T.L. w/c Shop	217
3	Pallet Die No.		15317 (4.0) w/c	200200
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790 w/c, Step on 792 w/c	Step length 28.5
6	Inside Diameter	Drg. No.	660.14 w/c	Under cut = 0.5 w/c
7	Width of Pellet Die	Drg. No.	323.9 w/c	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 w/c 21.5 x 8 x 8 w/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		w/c Shop	Tapping of holes 12
12	Tapping PCD		725 w/c	Both Side
13	Tapping Hole Diameter		M20, Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 31.4 w/c	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi: 18/7/25	2 St. + 32.1 w/c width 8 w/c Deep Both Side
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	4.8 w/c	Outside 3-35	Inner 31 w/c
3	External Relief Depth		35 w/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		18 7 25	
Inspected By (Sign) & Date			Ravi: 18/7/25	

Reviewed by (Engineer-CNC)

Manager-QA