



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.		15275	29/6
2	Machined By		V. T. L. H/c Shop	Dry H/c 18.02.2015
3	Pallet Die No.		14754 (2.8) H/c	Rev. 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/c	Step 00, 801 H/c
6	Inside Diameter	Drg. No.	660.12 H/c / 661.12 H/c	Step length 9.5"
7	Width of Pellet Die	Drg. No.	316 H/c	Step length 28 H/c
8	Grooves as per Drawing	Drg. No.	18 x 9 x 6 H/c / 18 x 9 x 6.5 H/c	Under cut 10.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		725 H/c	
13	Tapping Hole Diameter		H/c	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22.4 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/8/25

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

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	3.3 H/c	outside (3.3)			Inner				Row 2 59
3	External Relief Depth		34 H/c			31 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

Ravi 19/8/25

Reviewed by (Engineer-CNC)

Manager-QA