



Lark Engineering Company (India) Pvt. Ltd.

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

10334

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.		15425 ✓	53/58 ✓
2	Machined By		V. T. L. H/C Shop	Dry run 18.0.810
3	Pallet Die No.		12805 (3.8) H/C	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	745.5 H/C	Step 00, 743 H/C
6	Inside Diameter	Drg. No.	630.12 H/C	(Bore: 629.2 H/C) Step length 287.5
7	Width of Pellet Die	Drg. No.	255 H/C	Discussed & Approved
8	Grooves as per Drawing	Drg. No.	22 x 8 x 7 H/C	By Naveen Singh
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		685 H/C	Tapping H/C of holes 12
13	Tapping Hole Diameter		H22 = Check by H22 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 28.4 H/C	Tapping Depth 26.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 22/7/25

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 - 5 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter Boly

1	Counter Sinking Depth & Finish	OK						Raw: 22/7/25
2	External Relief Dia	4.3 H/C	Outside 2-3		Inner			
3	External Relief Depth		12 H/C		5 H/C			
4	Inspection Done Before Hardening By (Name)							Raw: 22/7/25
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		22	7	25			

Inspected By (Sign) & Date

Raw: 22/7/25

Reviewed by (Engineer-CNC)

Manager-QA