



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.			
2	Machined By		15642	55/66
3	Pallet Die No.		V.T.L. H/C Shop	50/66
4	Die Category	Drg. No.	15566(8.0)H	30/4.18.0
5	Out Side Diameter	Drg. No.	H. Jumbo	320
6	Inside Diameter	Drg. No.	680.2 H, Step 002	693 H
7	Width of Pellet Die	Drg. No.	546.14 H (Box: 548.2)	Tapper: 8
8	Grooves as per Drawing	Drg. No.	195 H	Undercut: 2.8 H
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.1 H 32.7 x 9.1 H (408)	
10	Drilling Area Surface Smoothness		OK	Face Side
11	Tapping Operator		OK	2 H Back
12	Tapping PCD		H/C Shop	Both Side
13	Tapping Hole Diameter		619 H	Tapping dia
14	Tapping On Second Side	Half pitch of 1st side	HIG: Check by HIG Bolt	of holes: 2
15	Tapping Hole Depth		OK	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth: 33.6 H	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		yes OK	

Inspected By (Sign) & Date

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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: 30
2	External Relief Dia	9.0 H	Is Pad	Is Pad				Row: 10
3	External Relief Depth	11 H	6 H					
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		31	7	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA