



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.		15632	55 / 60
2	Machined By		V.T.L. H/C Shop	Dy. H. L.D. 32
3	Pallet Die No.		15565 (8.0) H/C	Rev. 08
4	Die Category	Drg. No.	H. Tomb	
5	Out Side Diameter	Drg. No.	680.144	Step 00. 693 H/C Tapper 8°
6	Inside Diameter	Drg. No.	546.144 (Bos. 548.2) H/C	Step length. 31.7
7	Width of Pellet Die	Drg. No.	195 H/C	Under cut. 9.8 H/C
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.144 / 32 x 7 x 9.1 H/C	(4 x 8) H/C
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		H/C Shop	2 H/C Deep
12	Tapping PCD		619 H/C	Body Side
13	Tapping Hole Diameter		H162	Check by H16 Ball
14	Tapping On Second Side	Half pitch of 1st side	OK	Tapping Holes. 2 Body S.W.
15	Tapping Hole Depth		Drill Depth. 233.6 H/C	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		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. 31
2	External Relief Dia	9.0 H/C	All Rows					Row = 10
3	External Relief Depth		11 H/C					
4	Inspection Done Before Hardening By (Name)		Rev:					
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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Satyam
31/7/25

Reviewed by (Engineer-CNC)

Manager-QA