



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.		15217	
2	Machined By		V.T.L. H/C Shop	55/66
3	Pallet Die No.		16085(8.0)H/C	Qty 18.2.136
4	Die Category	Drg. No.	M. 70mbo	Rev. 01
5	Out Side Diameter	Drg. No.	680.14H/C	
6	Inside Diameter	Drg. No.	Step 00. 693H/C	Tapper. 8°
7	Width of Pellet Die	Drg. No.	546.14H/C (Bo. 548.2)	Step length. 31.3H/C
8	Grooves as per Drawing	Drg. No.	205.6H/C	Under cut. 2.78H/C
9	Fitting Sizes on CNC Plate	Drg. No.	32.3x6x9.1H/C / 32.3x6x9.1H/C	(4x8x4x8)H/C
10	Drilling Area Surface Smoothness		ok	Face Side
11	Tapping Operator		ok	Step 2.3H/C
12	Tapping PCD		H/C Shop	Back Side
13	Tapping Hole Diameter		619H/C	Tapping H/C
14	Tapping On Second Side	Half pitch of 1st side	H16. Check by H16 Ball	of Holes. 2
15	Tapping Hole Depth		ok	Back Side
16	Perpendicularity of Tapped Hole		Drill Depth. 33.6H/C	Tapping Depth. 31.6
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 30/7/25

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

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	9.0H/C			All Rows			Row. 10
3	External Relief Depth				11H/C			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Burnane			
6	Material Sent For Hardening On Date				30	7	25	

Inspected By (Sign) & Date

Ravi 30/7/25

Reviewed by (Engineer-CNC)

Manager-QA