



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	55/66
2	Machined By		V. T. L. n/c Shop	Dy. M. L. R. 136
3	Pallet Die No.		16086 (8.0) n/c	Rev. of
4	Die Category	Drg. No.	H. 70 m h	
5	Out Side Diameter	Drg. No.	680.2 n/c	Step 00. 693 n/c
6	Inside Diameter	Drg. No.	546.14 n/c	(Bos. 548.2) n/c
7	Width of Pellet Die	Drg. No.	205.6 n/c	Step length = 91.3 n/c
8	Grooves as per Drawing	Drg. No.	32.3 x 6 x 9.1 n/c	Under cut = 28 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	(4 x 8 x 4 x 8) n/c
10	Drilling Area Surface Smoothness		OK	Face side step
11	Tapping Operator		n/c Shop	2.3 n/c Deep
12	Tapping PCD		619 n/c	Back side
13	Tapping Hole Diameter		M16	Tapping no. of hole. 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Back side
15	Tapping Hole Depth		Drill Depth. 33.6 n/c	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		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

Counter. 30
Ravi 10

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	9.0 n/c		All Rows			
3	External Relief Depth			11 n/c			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date			30	7	25	

Inspected By (Sign) & Date

Ravi 20/7/25

Satish 30/7/25

Reviewed by (Engineer-CNC)

Manager-QA