



Lark Engineering Company (India) Pvt. Ltd.

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

10410

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.		15606	55/55
2	Machined By		V.T.L. H/C Shop	Qty. 12.0-4.7
3	Pallet Die No.		15346(4.0) H/C	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	709.9 H/C	Step 00.692.8 H/C
6	Inside Diameter	Drg. No.	600.14 H/C	Tapper 12"
7	Width of Pellet Die	Drg. No.	222 H/C	Step length 8 H/C
8	Grooves as per Drawing	Drg. No.	12x8x7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x7 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		M20 - Check by M20 Ball	Tapping No. of holes 12
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 20.4 H/C	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi: 11/8/25

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 60
2	External Relief Dia	4.5 H/C	Outside (3-3)		Inner			Rev. 30
3	External Relief Depth		5 H/C		Mill			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date				11/8/25			

Inspected By (Sign) & Date

Ravi: 11/8/25

Reviewed by (Engineer-CNC)

Manager-QA