



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)

10403

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15673	20/06
2	Machined By		V.T.L. H/c Shop	Dr. H. 12.609
3	Pallet Die No.		15549(9.0) H/c	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm	Step 00 - 693 mm
6	Inside Diameter	Drg. No.	546.14 mm	(Bore = 548.4) mm
7	Width of Pellet Die	Drg. No.	195 mm	Step length 31 mm
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 mm	(4 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		H/c	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.7 mm	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rev: 21/8/25

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

Counter: 60

1	Counter Sinking Depth & Finish	OK						Rev. 8
2	External Relief Dia	10.0 mm		All Rows				
3	External Relief Depth			4 mm				
4	Inspection Done Before Hardening By (Name)			Rev:				
5	Material Sent For Hardening By (Name)			Lark Perforce				
6	Material Sent For Hardening On Date		2	8	25			

Inspected By (Sign) & Date

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Manager-QA

Reviewed by (Engineer-CNC)