



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)

10521

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15903	35/40/86
2	Machined By		V.T.L. H/c Shop	Dry No. 12.0320
3	Pallet Die No.		15750 (G.O) H/c	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/c Shop on 693 H/c	Tapper 3"
6	Inside Diameter	Drg. No.	546.14 H/c (1300 - 548.2)	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Identical 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c	(4 x 2)
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 H/c	
13	Tapping Hole Diameter		H/c 2 Crack by H/c hole	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.6 H/c	Tapping Depth 31.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/7/25

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
Row 2 12

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5 H/c H/c	6.5 H/c All Rows 2	31 H/c			
3	External Relief Depth		7.0 H/c All Rows 2	26 H/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Porroce				
6	Material Sent For Hardening On Date		2	9	25		

Inspected By (Sign) & Date

Ravi 29/7/25

Reviewed by (Engineer-CNC)

Manager-QA