



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.		15859	19/66
2	Machined By		V.T.L. H/c Shop	Qty 12.060
3	Pallet Die No.		15861 (G.O) H/c	Revised
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c	693 H/c Tapper 8°
6	Inside Diameter	Drg. No.	546.14 H/c (Box = 548.4) H/c	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Order cost 25 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 H/c	32.7 x 9.2 H/c (4 x 8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side
11	Tapping Operator		H/c Shop	Step 2 H/c
12	Tapping PCD		619 H/c	Deep Bottom
13	Tapping Hole Diameter		H162	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 H/c	Tapping Depth 31 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 9/9/25

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
Box 12

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	7.5 H/c		All Rows			
3	External Relief Depth			47 H/c			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Purrace			
6	Material Sent For Hardening On Date		9	9	25		

Inspected By (Sign) & Date

Ravi 9/9/25

Satish 9/9/25

Reviewed by (Engineer-CNC)

Manager-QA