



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.		16097	41/65
2	Machined By		V.T.L M/c Shop	Day No. 1.3.D.788
3	Pallet Die No.		16261 (6.0) H4	Renol
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	678 H4	Step OD. 693 H4 Tappet 8°
6	Inside Diameter	Drg. No.	546.12 H4 (Box 548.4)	Step length 28 H4
7	Width of Pellet Die	Drg. No.	195 H4	End cut 2.86 H4
8	Grooves as per Drawing	Drg. No.	31x8x9.2 H4 / 31x8x9.2 H4	(5x8) H4
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side 8 Tappet
10	Drilling Area Surface Smoothness		OK	Deep Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		619 H4	of Holes = 2
13	Tapping Hole Diameter		H18 Check by H18 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 38.4 H4	Tapping depth = 36
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 20/9/25

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 = 39°

1	Counter Sinking Depth & Finish	OK						Row 212
2	External Relief Dia	7.0 H4		All	Row 2			
3	External Relief Depth				24 H4			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark furnace			
6	Material Sent For Hardening On Date				20	9	25	

Inspected By (Sign) & Date

Ravi 20/9/25

Reviewed by (Engineer-CNC)

Manager-QA