



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	Dry No. 13.2788
3	Pallet Die No.		16262 (6.0) H	Removal
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	678 H	Step 00.693 H
6	Inside Diameter	Drg. No.	546.14 H (Bar = 548.4) H	Tapper = 8°
7	Width of Pellet Die	Drg. No.	194.9 H	Step length = 38 H
8	Grooves as per Drawing	Drg. No.	31x8x9.2 H / 31x8x9.2 H (5x8)	Under cut = 2.86 H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Pare Side Step
10	Drilling Area Surface Smoothness		OK	OK Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		619 H	of Holes = 2
13	Tapping Hole Diameter		H16, Check by H16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 38.4 H	Tapping depth = 38.4 H
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				
1	Counter Sinking Depth & Finish	OK		Counter = 30
2	External Relief Dia	1.0 H	All Pass	Row 212
3	External Relief Depth		24 H	
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