



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		16084	22/32/66
2	Machined By		V.T.I M/c Shop	23/33/86
3	Pallet Die No.		16260 (6.0)mm	Dry No. 13cl-302
4	Die Category	Drg. No.	M. Jumbo	(Rev 00)
5	Out Side Diameter	Drg. No.	680mm	Step OD = 692.9mm Tapper 5°
6	Inside Diameter	Drg. No.	548.14mm (Bor = 548.2)mm	Step Length 28.5mm
7	Width of Pellet Die	Drg. No.	195mm	Under cut = 3.4mm
8	Grooves as per Drawing	Drg. No.	26.5 x 10 x 9.1mm	26.5 x 10 x 9.1mm (G+8)mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		619mm	of Holes
13	Tapping Hole Diameter		H16	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 32.4mm	Tapping depth = 30.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi

26/9/25

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	Test Pad	Final	Counter-30
2	External Relief Dia	6.5mm	44mm	6.5mm	Row 2-12
3	External Relief Depth	1.5mm	34mm	1.5mm	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		26	9	25

Inspected By (Sign) & Date

Ravi

26/9/25

Reviewed by (Engineer-CNC)

Manager-QA