



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

10760

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		18141	40/50/70
2	Machined By		V.T.L. H/c Shop	Dry No = 1.2.0.327
3	Pallet Die No.		15375(8.0) H/c	Rev 203
4	Die Category	Drg. No.	N. Jom ho	
5	Out Side Diameter	Drg. No.	688 H/c	Step OD = 697.7 H/c, Tapper = 5°
6	Inside Diameter	Drg. No.	546.12 H/c (Box = 548.3)	Step length = 38.5
7	Width of Pellet Die	Drg. No.	215 H/c	Under cut = 1.8 H/c
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 9.2 H/c / 29.5 x 10 x 9.2 H/c (6 x 2)	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	Low Deep Both Side
11	Tapping Operator		H/c Shop	Tapping No
12	Tapping PCD		618 H/c	of Holes = 2
13	Tapping Hole Diameter		H/c = Check by H/c 8.12	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 32.4 H/c	Tapping depth = 30.9
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 27/9/25

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 = 300

Row = 12

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	8.5 H/c / 9.0 H/c	8.5 H/c	All Rows = 2	30 H/c			
3	External Relief Depth		9.0 H/c	All Rows = 2	20 H/c			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		27	9	25			

Inspected By (Sign) & Date

Ravi 27/9/25

Manager-QA

Reviewed by (Engineer-CNC)