



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)

10833

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16189 ✓	55/66
2	Machined By		V. T. L. H/L Shop	Dr. No. 18.0 32
3	Pallet Die No.		16456 (10.0) H/L	Rev. 02
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/L	Step 00. 293 H/L
6	Inside Diameter	Drg. No.	546.14 H/L (Ber: 548.2)	Tapper 8
7	Width of Pellet Die	Drg. No.	195 H/L	Step length 31.4
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/L	Under cut 2.8 H/L
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.1 H/L	(4 x 8) H/L
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		H/L Shop	2 H/L Deep
12	Tapping PCD		619 H/L	Both Side
13	Tapping Hole Diameter		H16	Tapping H/L
14	Tapping On Second Side	Half pitch of 1st side	Check by H16 Bolt	of holes 2
15	Tapping Hole Depth		OK	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.4 H/L	Tapping Depth 31.4
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Ravi 9/10/25

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 60
2	External Relief Dia	11.0 H/L	All Rows						Row 2
3	External Relief Depth		11 H/L						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Parnace						
6	Material Sent For Hardening On Date		9	10	25				
Inspected By (Sign) & Date			Ravi 9/10/25						

Reviewed by (Engineer-CNC)

Manager-QA