



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.		16241	17/66
2	Machined By		V.T.L. H/a Shop	Dy. No. 12.0.09
3	Pallet Die No.		16465 (G.10) H/a	Rev. 03
4	Die Category	Drg. No.	H. Jumbo	counter
5	Out Side Diameter	Drg. No.	680.7 H/a	693 H/a
6	Inside Diameter	Drg. No.	546.12 H/a (Bar - 548.4)	Tapping 8"
7	Width of Pellet Die	Drg. No.	195 H/a	Step Length 3"
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 H/a / 32.7 x 9.2 H/a	Undercut 2.5 H/a
9	Fitting Sizes on CNC Plate	Drg. No.	OK	478
10	Drilling Area Surface Smoothness		OK	Face side step
11	Tapping Operator		H/a Shop	9 H/a Dark Bar
12	Tapping PCD		619 H/a	Side
13	Tapping Hole Diameter		H/a. Check by H/a Bolt	Tapping H/a
14	Tapping On Second Side	Half pitch of 1st side	OK	of holes 2
15	Tapping Hole Depth		Drill Depth 33.4 H/a	Both Side
16	Perpendicularity of Tapped Hole		Yes	Tapping Depth 31.4
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 10/10/25	
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 31
2	External Relief Dia	7.5 H/a		Rev. 12
3	External Relief Depth		49 H/a	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		10 10 25	
Inspected By (Sign) & Date			Ravi 10/10/25	

Reviewed by (Engineer-CNC)

Manager-QA