



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.		16189	55/60
2	Machined By		V.T.L. M/c Shop	Dry No. 2 12.0.32
3	Pallet Die No.		16457 (10.0) 44	Ren 08
4	Die Category	Drg. No.	M. 700 h0	
5	Out Side Diameter	Drg. No.	680.1 44	Step 0D 2 69.3 44 Tapp 8
6	Inside Diameter	Drg. No.	546.12 44 (302.548.2)	Step length 4.31 44
7	Width of Pellet Die	Drg. No.	195 44	End cut 0.3 44
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 44	(4 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side 44
10	Drilling Area Surface Smoothness		OK	2 44 Back Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		619 44	of Holes 2 2
13	Tapping Hole Diameter		W162 Check by W16 B-14	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 2 33.4 44	Tapping depth 31.6
16	Perpendicularity of Tapped Hole		yes	
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	outside	Furnace				Counter=60
2	External Relief Dia	11.0 44		All Rows				Row 2 8
3	External Relief Depth			11 44				
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