



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

10842

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	58/66
2	Machined By		V.T.I. M/c Shop	Dry No. 2-1.2.0.320
3	Pallet Die No.		16458 (10.0) 44	Ren 08
4	Die Category	Drg. No.	H. Joubert	
5	Out Side Diameter	Drg. No.	680.144	Step OD: 693.44, Tapper: 8
6	Inside Diameter	Drg. No.	546.144 (Bor: 588.2)	Step length: 31
7	Width of Pellet Die	Drg. No.	19544	Under cut: 28
8	Grooves as per Drawing	Drg. No.	32x7x9.1 44	(Cues)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	Gun Deep Bore
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		61944	of Holes: 2
13	Tapping Hole Diameter		416	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth: 33.44	Tapping depth: 31.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/10/25

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	Inner	Counter 260
2	External Relief Dia	11.044		Drill holes	Row = 8
3	External Relief Depth			844	
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