



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.		18298	30/66
2	Machined By		V. T. L. H/c Shop	Dr. H. 1.2.0.930
3	Pallet Die No.		16470 (B.O.)	Rev. 08
4	Die Category	Drg. No.	H. Tumbo	Rev. 08
5	Out Side Diameter	Drg. No.	680.1 H/c Shop	692.9 H/c Shop
6	Inside Diameter	Drg. No.	546.14 H/c (Box - 546.2)	Step length 314
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut. d. 75 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c	32 x 7 x 9.1 H/c (4 x 2)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step
10	Drilling Area Surface Smoothness		ok	2 H/c Deep
11	Tapping Operator		H/c Shop	Back side
12	Tapping PCD		619 H/c	Tapping H/c
13	Tapping Hole Diameter		M16. Check by M16 Bolt	of Hole. 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Back side
15	Tapping Hole Depth		Drill Depth. 33.4 H/c	Tapping Depth. 314
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/10/25

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 30
2	External Relief Dia	7.0 H/c		All Rows				Rev. 12
3	External Relief Depth			36 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			14	10	25		

Inspected By (Sign) & Date

Ravi 14/10/25

Reviewed by (Engineer-CNC)

Manager-QA