



Lark Engineering Company (India) Pvt. Ltd.

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

10899

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.		16262	45/66
2	Machined By		V.T.L. H/c Shop	By No. 18.2 = 36
3	Pallet Die No.		16090 (8.0) H/c	Rev. 01
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/c	Step 02. 693 H/c
6	Inside Diameter	Drg. No.	546.14 H/c (Box 2 548.2)	Tappet. 2°
7	Width of Pellet Die	Drg. No.	205.6 H/c	Step length 31.3 H/c
8	Grooves as per Drawing	Drg. No.	32.3 x 6 x 9.1 H/c	Order cut = 2.8 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32.3 x 6 x 9.1 H/c	(4 x 8 x 4)
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		H/c Shop	2.3 H/c Depth
12	Tapping PCD		619 H/c	Both Side
13	Tapping Hole Diameter		H/c	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	H/c. Check by H/c Bolt	H/c. 2
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth: 33.4 H/c	Tapping Depth 31.4
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 16/10/25

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	9.0 H/c						20 rows
3	External Relief Depth							21 H/c
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date							16 10 25

Inspected By (Sign) & Date

Ravi 16/10/25

Satya 16/10/25

Reviewed by (Engineer-CNC)

Manager-QA