



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)

11000

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16433 ✓	35/50 ✓
2	Machined By		V. T. L. H/C Shop	Dr H. 12.0. 450
3	Pallet Die No.		15800 (4.0) H/C	Rev. 02 ✓
4	Die Category	Drg. No.	740	
5	Out Side Diameter	Drg. No.	730 H/C, Step 00-743.9 H/C	Tabber 210°
6	Inside Diameter	Drg. No.	630.14 H/C	Step length 23.3
7	Width of Pellet Die	Drg. No.	290.6 H/C	23.4
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 H/C / 15.3 x 8 x 5 H/C	Under cut 7 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face side Step
11	Tapping Operator		H/C Shop	0.8 H/C Deep
12	Tapping PCD		685 H/C	Both Side
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	Tapping Holes
14	Tapping On Second Side	Half pitch of 1st side	OK	Holes 16
15	Tapping Hole Depth		Drill Depth 20.4 H/C	Both Side
16	Perpendicularity of Tapped Hole		Yes	Tapping Depth 18.3 H/C
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 3/11/25

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 260

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	4.5 H/C	Outside (3-3)	Inner				
3	External Relief Depth		19 H/C	15 H/C				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date							

Inspected By (Sign) & Date

Ravi 3/11/25

3/11/25

Reviewed by (Engineer-CNC)

Manager-QA