



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.		10812	48/73/90
2	Machined By		V. T. L. H/c Shop	Dy. M. S. G. 738
3	Pallet Die No.		11171 (8.0) H/c	Revised
4	Die Category	Drg. No.	H. Tomba	
5	Out Side Diameter	Drg. No.	780H/c Step OD 703H/c	Tapper 4°
6	Inside Diameter	Drg. No.	600.12 H/c	Step length 23H/c
7	Width of Pellet Die	Drg. No.	221 H/c	
8	Grooves as per Drawing	Drg. No.	57x6x10 H/c	57x6x10 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes 12 Both Side
12	Tapping PCD		655 H/c	
13	Tapping Hole Diameter		MIG = Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 25.4 H/c	Tapping Depth 23.4 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 12/12/25

1 As per programme no.

2 Gun Drilling Work Completed On

3 Hole Finish In Gun Drilling Marked

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							Rev 9
2	External Relief Dia	8.5H/c 9.0H/c	8.5H/c All Lines			9.0H/c All Lines			
3	External Relief Depth		42H/c			17H/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		12	12	23				

Inspected By (Sign) & Date

Ravi 12/12/25

Reviewed by (Engineer-CNC)

Manager-QA