



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.		15431 ✓	30/66 ✓
2	Machined By		V. T. L. n/c Shop	Qty No. 12.0.320
3	Pallet Die No.		15542 (6.0) n/c	Rev. 08
4	Die Category	Drg. No.	M. 70m 50	
5	Out Side Diameter	Drg. No.	680.1 n/c Step 00 = 693 n/c	Tabber = 8
6	Inside Diameter	Drg. No.	546.12 n/c (Bore 548.2 n/c)	Step length = 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	End cuts 2.9 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 n/c 32 x 7 x 9.1 n/c	(4 x 2) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Face side gap]
11	Tapping Operator		n/c Shop	[Gun Deep Bar]
12	Tapping PCD		619 n/c	Side
13	Tapping Hole Diameter		M16, Check by M16 Bolt	[Tapping Holes]
14	Tapping On Second Side	Half pitch of 1st side	ok	[of holes = 2]
15	Tapping Hole Depth		Drill Depth 133.4 n/c	[Both Side]
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rev. 12/7/25

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 n/c		All Bore					Rev. 12
3	External Relief Depth			36 n/c					
4	Inspection Done Before Hardening By (Name)			Rev.					
5	Material Sent For Hardening By (Name)			Lark Formae					
6	Material Sent For Hardening On Date			12	7	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA