



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)

10326

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15564 ✓	30/66 ✓
2	Machined By		V.T.L. n/c Stop	Qty. 120 = 32
3	Pallet Die No.		15541 (6.0) n/c	Rev. 08
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 n/c	Step 00, 693 n/c
6	Inside Diameter	Drg. No.	546.12 n/c (Box 2 548.2)	Step length = 21 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	1200 cut = 2.3 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 9) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 n/c Deep
11	Tapping Operator		n/c Stop	Both Side
12	Tapping PCD		619 n/c	Tapping n/c
13	Tapping Hole Diameter		n/c, Check by n/c Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth = 33.4 n/c	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

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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

Counter, 31

1	Counter Sinking Depth & Finish	OK						Rev: 12
2	External Relief Dia	7.0 n/c		All Rows				
3	External Relief Depth			36 n/c				
4	Inspection Done Before Hardening By (Name)			Rev:				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		22	7	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA