



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.			
2	Machined By		15463	55/66
3	Pallet Die No.		N.T.L. H/C Shop	Day 11.12.0.320
4	Die Category	Drg. No.	15341 (8.0) H/C	Ren. 08
5	Out Side Diameter	Drg. No.	H. Tomb	443
6	Inside Diameter	Drg. No.	680.2 H/C Step 002	693 H/C Tappers
7	Width of Pellet Die	Drg. No.	546.14 H/C (Box: 548.2)	Step length = 31
8	Grooves as per Drawing	Drg. No.	195 H/C	Under cut, 2.7
9	Fitting Sizes on CNC Plate	Drg. No.	32x7x9.1 H/C / 32x7x9.1 H/C (4x8)	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		OK	2 H/C Reap
12	Tapping PCD		N/A Shop	Both Side
13	Tapping Hole Diameter		619 H/C	Tapping 1.1
14	Tapping On Second Side	Half pitch of 1st side	N/A Check by H/C B11	of H/C 2
15	Tapping Hole Depth		OK	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.6 H/C	Tapping Depth B1.6
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

Raw: 23/7/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
4	Defective Holes (If Any)		OK 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			All Rows			Row 10
3	External Relief Depth				11 H/C			
4	Inspection Done Before Hardening By (Name)				Raw:			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		23	7	25			

Inspected By (Sign) & Date

Raw: 23/7/25

23/7/25

Reviewed by (Engineer-CNC)

Manager-QA