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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.		16141	40/50/70
2	Machined By		V.T.L. M/c Shop	Dry No. 1.3.2 377
3	Pallet Die No.		15376 (8.0) M	Rev. 08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 M	Step OD = 697.7 M
6	Inside Diameter	Drg. No.	546.12 M (B. 548.3)	Step length = 38.5
7	Width of Pellet Die	Drg. No.	215 M	Undercut = 1.8 M
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 9.2 M	(6 x 8) M
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	Inner Deep Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		618 M	of Holes = 2
13	Tapping Hole Diameter		M/c, Check by M/c Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 32.4 M	Tapping depth = 30.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 27/9/25	
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 290
2	External Relief Dia.	8.5 M / 9.0 M	8.5 M All Done = 30 M	Row 212
3	External Relief Depth		9.0 M All Done = 20 M	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		27 9 25	
Inspected By (Sign) & Date			Ravi 27/9/25	

Sats 27/9/25

Reviewed by (Engineer-CNC)

Manager-QA