



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13255 ✓	22/32/66
2	Machined By		VTK MIC Shop	23/33/66
3	Pallet Die No.		13785 (6.0) mm	Dr. 11-802 Rev
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	Ø 680 mm, OD Step-693 mm	Step height-385 mm
6	Inside Diameter	Drg. No.	546.1 mm	Taper 5°
7	Width of Pellet Die	Drg. No.	195 mm	
8	Grooves as per Drawing	Drg. No.	26.5 x 10 x 9, 26.8 x 10 x 9 mm	(6 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shop	Tapping Ho of Hols - 2 Both side
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16 check M16 Bolt	(face over 28 x 1 mm)
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth-33 mm Tapping Depth-30.5 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

[Signature] 11/11/24

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
1 Counter Sinking Depth & Finish	30°
2 External Relief Dia	Ø 65, 7.0 1st step
3 External Relief Depth	Ø 65 44 mm, Ø 65 43 mm, Ø 7.0 33 mm
4 Inspection Done Before Hardening By (Name)	Sanjay
5 Material Sent For Hardening By (Name)	works Form
6 Material Sent For Hardening On Date	11 11 24

Inspected By (Sign) & Date

[Signature] 11/11/24

[Signature] 11/11/24

Reviewed by (Engineer-CNC)

Manager-QA