



# 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.		13162	19/66
2	Machined By		V.T.L. N/A Shop	Dy. No. 13.2.509
3	Pallet Die No.		13622 (G.6)	Rev. 03
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7mm, Step 00, 692mm	Tabber, 8°
6	Inside Diameter	Drg. No.	546.12mm   548.12mm (P. 548.1)	Step length 31mm
7	Width of Pellet Die	Drg. No.	195mm	Lead angle 2.5mm
8	Grooves as per Drawing	Drg. No.	32x7x91mm   32x7x81mm (4x8)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Step 2mm Deep Bottom
11	Tapping Operator		N/A Shop	Side
12	Tapping PCD		619mm	Tapping No.
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	of Holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.4mm	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 25/11/24

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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, 30°

1	Counter Sinking Depth & Finish	ok							Rev 12
2	External Relief Dia	7.5mm	All Rows						
3	External Relief Depth		47mm						
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		25	11	24				

### Inspected By (Sign) & Date

Ravi 25/11/24

Satish 25/11/24

Reviewed by (Engineer-CNC)

Manager-QA