



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	22/66
2	Machined By		V. T. L. N/C Shop	Drill No. 13.0.0.09
3	Pallet Die No.		13623 (B.O) N/C	Row 03
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm, Step 00, 693 mm	Tabber, 8°
6	Inside Diameter	Drg. No.	548.12 mm (Bot: 548.1)	Step length 3 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut, 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 91 mm (32 x 7 x 91 mm)	(4 x 2)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	face side step
10	Drilling Area Surface Smoothness		ok	2 mm Deep Bottom
11	Tapping Operator		N/C Shop	Side
12	Tapping PCD		619 mm	Tapping No.
13	Tapping Hole Diameter		N/C Check by N/C Bolt	of 4.0 x 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Bottom Side
15	Tapping Hole Depth		Drill Depth, 33.3 mm	Tapping Depth, 31.4 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Row: 25/11/24

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, 60°
Row 02/12

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	1.5 mm	1.5 mm	All Rows			
3	External Relief Depth			44 mm			
4	Inspection Done Before Hardening By (Name)			Row			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		25	11	24		

Inspected By (Sign) & Date

Row: 25/11/24

Sato
25/11/24

Reviewed by (Engineer-CNC)

Manager-QA