



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.		13615 13622	26/64/78
2	Machined By		V.T.L. n/c Shop	Dy. No. 13.9296
3	Pallet Die No.		13615 (6.5) n/c	Rev. 01
4	Die Category	Drg. No.	M. Tomba	
5	Out Side Diameter	Drg. No.	636 n/c / 632 n/c / Step OD = 630.5 n/c / 543 n/c	
6	Inside Diameter	Drg. No.	480.12 n/c / 489.12 n/c / 500.12 n/c / Step length = 28 n/c / 18.5 n/c	
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	37 x 12 x 8 x 9.5 n/c / 27 x 12 x 8 x 9.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 4
12	Tapping PCD		540 n/c	
13	Tapping Hole Diameter		M16: Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and 1st side One Slot	
15	Tapping Hole Depth		Drill Depth = 28.3 n/c Tapping Depth = 26.5 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 18/12/5	1 Slot 28.1 n/c width 17 n/c Deep
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 = 30° Row = 9
2	External Relief Dia	7.0 n/c / 7.5 n/c	7.0 n/c All Rows = 42 n/c	
3	External Relief Depth	/	7.5 n/c All Rows = 14 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		18 / 1 / 25	
Inspected By (Sign) & Date			Ravi 18/12/5	

Reviewed by (Engineer-CNC)
18/11/25

Manager-QA