



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)

9/26

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13406	48/97
2	Machined By		V. T. L. n/c Shop	55/97
3	Pallet Die No.		14226 (8.0) n/c	Dy. n/c, 1.8.9.12/8
4	Die Category	Drg. No.	S. Jumbo	Rev. 00
5	Out Side Diameter	Drg. No.	1066.6 n/c	Step OD = 1077 n/c Tapper 8°
6	Inside Diameter	Drg. No.	848.12 n/c (Bore = 850.12 n/c)	Step length 43 n/c
7	Width of Pellet Die	Drg. No.	266.2 n/c	Under cut = 11.5 n/c
8	Grooves as per Drawing	Drg. No.	45 x 8 x 9.6 n/c / 45 x 8 x 9.6 n/c	2 n/c Deep
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Both Side
10	Drilling Area Surface Smoothness		ok	Tapping n/c of Holes & Both Side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		950 n/c	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 42.4 n/c	Tapping Depth = 40 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/1/25

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 Bo
2	External Relief Dia	9.0 n/c	1st Pad	2nd Pad			Row 14
3	External Relief Depth		49 n/c All Rows	42 n/c All Rows			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		31	1	25		

Inspected By (Sign) & Date

Ravi 31/1/25

Satya 31/1/25

Reviewed by (Engineer-CNC)

Manager-QA