



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.		14084 ✓	33166 ✓
2	Machined By		V.T.L. M/C Shop	Dr. No. 1.80.609
3	Pallet Die No.		14389 (6.0) M/C	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7mm Step 00. 692.7mm	Tapper. 8°
6	Inside Diameter	Drg. No.	546.12mm (Bar = 548.4mm)	Step length. 3mm
7	Width of Pellet Die	Drg. No.	195mm	Under cut = 2.5mm
8	Grooves as per Drawing	Drg. No.	32x7x9.2mm 32x7x9.2mm (4x2)mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face side Step 8mm Deep Buta Side
11	Tapping Operator		M/C Shop	
12	Tapping PCD		619mm	Tapping No of Holes, 2 Buta Side
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 33.3mm	Tapping Depth - 31.5mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/2/25

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

Counter = 30

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	7.5mm	All	Rows					
3	External Relief Depth			33mm					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date		17	2	25				

Inspected By (Sign) & Date

Ravi 17/2/25

Setsu 17/2/25

Reviewed by (Engineer-CNC)

Manager-QA