



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.		14084	33186
2	Machined By		V.T.L. H/c Shop	Drg No. 13.0.09
3	Pallet Die No.		14390 (6.0) H/c	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c, Step 60, 692.6 H/c	Tap here
6	Inside Diameter	Drg. No.	546.1 H/c (Box 548.4 H/c)	Step length 3 H/c
7	Width of Pellet Die	Drg. No.	195.1 H/c	Under cotr 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 H/c 32 x 7 x 9.2 H/c (4 x 3) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Face side Step 2 H/c Deep Bore Side]
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	[Tapping dia of holes 2 Bore Side]
13	Tapping Hole Diameter		H16 = Check by H16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2 H/c	Tapping Depth 3.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/2/25

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	7.5 H/c	All Rows						
3	External Relief Depth		33 H/c						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Purrace						
6	Material Sent For Hardening On Date		20	2	25				

Inspected By (Sign) & Date

Ravi 20/2/25

Reviewed by (Engineer-CNC)

Manager-QA