



# 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 ✓	33/86 ✓
2	Machined By		V.T.L N/A Shop	Drg No. 13.0-8.9
3	Pallet Die No.		14392 (6.0) ✓	Row = 03 ✓
4	Die Category	Drg. No.	Ni Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm, Step 00 = 692.8 mm	Tappers 8"
6	Inside Diameter	Drg. No.	546.12 mm (Box = 548.4 mm)	Step length = 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Wider cut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm   32 x 7 x 9.2 mm (4x8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[ Done Side Step 9 mm Deep Both side ]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	[ Tapping No of holes 2 Both Side ]
12	Tapping PCD		619 mm ✓	
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 = 33.2 mm	Tapping Depth = 31.5 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 20/7/25	
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	
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	ok		Counter, 80° Rop = 12
2	External Relief Dia	7.5 mm	All Rows	
3	External Relief Depth		33 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		20	2
Inspected By (Sign) & Date			Ravi 20/7/25	

Reviewed by (Engineer-CNC)  
Sats 20/7/25

Manager-QA