



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)

9262

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14167 ✓	38/53/66
3	Pallet Die No.		V.T.L. N/C Shop	Drg. No. 63.02.8.9
4	Die Category	Drg. No.	14506 (6.0) mm	Rev. 03
5	Out Side Diameter	Drg. No.	M. Jumbo	②
6	Inside Diameter	Drg. No.	680.7 mm / Step OD = 692.7 mm	Tappers 8
7	Width of Pellet Die	Drg. No.	546.12 mm / (Box = 548.4 mm)	Step length = 31 mm
8	Grooves as per Drawing	Drg. No.	195 mm ✓	Under cut = 2.5 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.2 mm / 32 x 7 x 9.2 mm	(478) mm
10	Drilling Area Surface Smoothness		ok	} Pure Side Step 2 mm Deep Bore
11	Tapping Operator		ok	
12	Tapping PCD		N/C Shop	} Side Tapping Holes of Holes 2 Bore Side
13	Tapping Hole Diameter		619 mm	
14	Tapping On Second Side	Half pitch of 1st side	M16 = Check by M16 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 33.3 mm	Tapping Depth = 31.7 mm
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

Inspected By (Sign) & Date

Ravi 22/2/25

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
Row 12

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm	All Rows = 28 mm ✓			
3	External Relief Depth		7.0 mm	All Rows = 13 mm ✓			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Forpiece			
6	Material Sent For Hardening On Date		22	2	25		

Inspected By (Sign) & Date

Ravi 22/2/25

Satyam 22/2/25

Reviewed by (Engineer-CNC)

Manager-QA