



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.		14161 ✓	40/60/66 ✓
2	Machined By		V.T.L n/c Shop	Drg No. 13.9.08-9
3	Pallet Die No.		14494 (G.O) n/c	Rev 203
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 n/c, Step OD: 692.7 n/c	Tappers 8°
6	Inside Diameter	Drg. No.	546.12 n/c (Bore = 548.4 n/c)	Step length 31.2 n/c
7	Width of Pellet Die	Drg. No.	195 n/c ✓	6d ex cnc = 2.5 n/c
8	Grooves as per Drawing	Drg. No.	327.7 x 9.2 n/c 327.7 x 9.2 n/c (4 x 8 n/c)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face side step
11	Tapping Operator		n/c Shop	same Deep Bore Dr
12	Tapping PCD		619 n/c	
13	Tapping Hole Diameter		n/c = Check by HIG Bolt	Tapping dia of holes = 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth = 33.3 n/c	Tapping Depth = 31.5 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rasi 21/2/25

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

1	Counter Sinking Depth & Finish	ok						Counter 30°
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c	All holes = 20 n/c ✓				
3	External Relief Depth		7.0 n/c	All holes = 6 n/c ✓				
4	Inspection Done Before Hardening By (Name)			Rasi				
5	Material Sent For Hardening By (Name)			Lark furnace				
6	Material Sent For Hardening On Date		21	2	25			
Inspected By (Sign) & Date		Rasi 21/2/25						

Reviewed by (Engineer-CNC)

Manager-QA