



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.		103913956	80/66
2	Machined By		V.T.L. n/c Shop	Digital 6.20.136
3	Pallet Die No.		14539(3.5) mm	Revol
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032.4 mm Step 0.01 1033 mm	Tapper 3°
6	Inside Diameter	Drg. No.	900.2 mm	Step length 0.2
7	Width of Pellet Die	Drg. No.	37.5 mm	Undercut 0.03 mm
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 mm / 29.5 x 8 x 13 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes 15
12	Tapping PCD		970 mm	Both Side
13	Tapping Hole Diameter		M24 Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 38.2 mm	Tapping Depth 38 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 13/3/25	2 Slot
1	As per programme no.			32.1 mm width
2	Gun Drilling Work Completed On			7.5 mm Dash
3	Hole Finish In Gun Drilling	Marked	ok	Both Side
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 6°
2	External Relief Dia	U. 0 mm	Outside (U-4)	Inner
3	External Relief Depth		13 mm	6 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		13 3 25	
Inspected By (Sign) & Date			Ravi 13/3/25	

Reviewed by (Engineer-CNC)

Manager-QA