



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.		14345	55/66
2	Machined By		V.T.C. M/c. Shop	Drg No. 1.3.0.0-9
3	Pallet Die No.		14503(8.0) M/c	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680-7 M/c 8th step 693 M/c	Tabber 8°
6	Inside Diameter	Drg. No.	546.12 M/c (Bore 548.4 M/c)	Step length 9 M/c
7	Width of Pellet Die	Drg. No.	195 M/c	Under cut 2.5 M/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 M/c	(4 x 8) M/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Race Side Step 2 M/c Deep Bottom Side Tapping No of holes 2 Bottom Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619 M/c	[Tapping No of holes 2 Bottom Side]
13	Tapping Hole Diameter		M16.2 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2 M/c	Tapping Depth 31.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/3/25

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	9.0 M/c		All Rows						Row 10
3	External Relief Depth			11 M/c						
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