



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 ✓	62166 ✓
2	Machined By		V.T.L. H/c Shop	Dy. H/c 1202609
3	Pallet Die No.		14556(9.0) H/c	Rev. 03 ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c, Step 00.693 H/c	Tabbers 8"
6	Inside Diameter	Drg. No.	546.12 H/c (Box = 548.4 H/c)	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Undercuts 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32.7 H/c 9.2 H/c, 32.7 H/c 9.2 H/c	(4.2) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 H/c Deep Both
11	Tapping Operator		H/c Shop	Side
12	Tapping PCD		619 H/c	Tapping H/c
13	Tapping Hole Diameter		H16, Crack by H16 Bolt	of Holes. 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.2 H/c	Tapping Depth 31.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/3/25

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						Count per 6"
2	External Relief Dia	10.0 H/c		All Rows				Rows 8
3	External Relief Depth			4 H/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		17	3	25			

Inspected By (Sign) & Date

Ravi 17/3/25

Reviewed by (Engineer-CNC)

Manager-QA