



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	62/66
2	Machined By		V.T.L. H/c Shop	Qty 10, 13-02-609
3	Pallet Die No.		14557 (9.0) H/c	Rev 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c Step 0.693 H/c Tapper 3	
6	Inside Diameter	Drg. No.	546.12 H/c (Bore 548.4 H/c)	Step length 3 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 H/c / 32.7 x 9.2 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step
10	Drilling Area Surface Smoothness		ok	2 H/c Deep Bottom
11	Tapping Operator		H/c Shop	Side
12	Tapping PCD		619 H/c	Tapping H/c
13	Tapping Hole Diameter		H16 - Check by H16 Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Bottom 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		Counter Sink
2	External Relief Dia	10.0 H/c	All Rnds	Rev - 8
3	External Relief Depth		4 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Farmace	
6	Material Sent For Hardening On Date		17 3 25	
Inspected By (Sign) & Date			Ravi 17/3/25	

Reviewed by (Engineer-CNC)

Manager-QA