



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 ✓	Q2/66
2	Machined By		V.T.L. n/c Shop	Dy. No. 13.0.69
3	Pallet Die No.		14558 (9.0) ✓	Rev. 03
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm Step 00. 693 mm	Tapper 8
6	Inside Diameter	Drg. No.	546.12 mm (Box 2 548.4 mm)	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm 32 x 7 x 9.2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Race Side Step 2 mm Deep Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Tapping n/c of holes 2 Both Side]
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2 mm Tapping Depth 31.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/3/25

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

Counter 8

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	10.0 mm			All Rows				
3	External Relief Depth				4 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		18	3	25				

Inspected By (Sign) & Date

Ravi 18/3/25

Reviewed by (Engineer-CNC)

Manager-QA