



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	32/66
2	Machined By		V. T. L. M/C. Shop	Qty 12.9269
3	Pallet Die No.		14559 (9.0) M/C	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.2 mm Step on 693 mm	Tappere 8
6	Inside Diameter	Drg. No.	546.12 mm (Box. 548.4 mm)	Step length 9 mm
7	Width of Pellet Die	Drg. No.	195 mm	End 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) (4 x 8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face side Step 2 mm Side
11	Tapping Operator		M/C. Shop	
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16 - Check by M16 Ball	Tapping No. of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Back Side
15	Tapping Hole Depth		Drill Depth 93.3 mm	Tapping Depth 91.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Savi 17/9/25	
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 8
2	External Relief Dia	10.0 mm	11 Rows	
3	External Relief Depth		4 mm	
4	Inspection Done Before Hardening By (Name)		Savi	
5	Material Sent For Hardening By (Name)		Lark Porance	
6	Material Sent For Hardening On Date		17 3 25	
Inspected By (Sign) & Date			Savi 17/9/25	

Reviewed by (Engineer-CNC)

Manager-QA