

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Inprocess Inspection (Pellet Dies)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Check Parameter	Specification	Observations	Remarks
Work Order No.		14411	40/50/70
Machined By		V.T.C. N/C Shop	Dr. No. 18.0 = 377
Pallet Die No.		14335 (8.0) N/C	Rev 203
Die Category	Drg. No.	M. Jumbo	
Out Side Diameter	Drg. No.	688 mm, Step 005 697.7 mm	Tapping 50
Inside Diameter	Drg. No.	546.12 mm (Bor = 548.2 mm)	Step length 38.5
Width of Pellet Die	Drg. No.	815 mm	Under cut = 1.7 mm
Grooves as per Drawing	Drg. No.	29.5 x 10 x 9.1 mm / 29.5 x 10 x 9.1 mm (B = 8) mm	
Fitting Sizes on CNC Plate	Drg. No.	ok	
Drilling Area Surface Smoothness		ok	
Tapping Operator		N/C Shop	
Tapping PCD		618 mm	
Tapping Hole Diameter		N/C = Check by N/C Bolt	
Tapping On Second Side	Half pitch of 1st side	ok	
Tapping Hole Depth		Drill Depth 32.2 mm	Tapping Depth 30.5
Perpendicularity of Tapped Hole		yes	
Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date		Raw: 20/3/25	
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	
2	External Relief Dia	8.5 mm / 9.0 mm	8.5 mm All Rows 2-30 mm
3	External Relief Depth	9.0 mm	All Rows 2 20 mm
4	Inspection Done Before Hardening By (Name)		Raw
5	Material Sent For Hardening By (Name)		Lark Porrace
6	Material Sent For Hardening On Date	22	3 25
Inspected By (Sign) & Date		Raw: 20/3/25	

Reviewed by (Engineer-CNC)

Manager-QA