



Lark Engineering Company (India) Pvt. Ltd.

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

9514

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.			
2	Machined By		14560	Bo/CC
3	Pallet Die No.		V-7-L N/C Shop	Drill No. 18.0 = 32
4	Die Category	Drg. No.	114772(10.0) N/C	Rev 208
5	Out Side Diameter	Drg. No.	N. 70m 60	
6	Inside Diameter	Drg. No.	680.1 mm Step 005 693 mm	Step length 91 mm
7	Width of Pellet Die	Drg. No.	546.12 mm (Box - 548.1 mm)	Tapper 8
8	Grooves as per Drawing	Drg. No.	195 mm	Width cut 22.8 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.1 mm / 32 x 7 x 9.1 mm	(4 x 2) mm
10	Drilling Area Surface Smoothness		ok	Face Side
11	Tapping Operator		N/C Shop	Step 2 mm Deep
12	Tapping PCD		619 mm	Both Side
13	Tapping Hole Diameter		N/C	Tapping No
14	Tapping On Second Side	Half pitch of 1st side	N/C Check by N/C Bolt	of holes 2
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.2 mm	Tapping Depth 31.5
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

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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 60
2	External Relief Dia	11.0 mm			All Rows				Rev 28
3	External Relief Depth				6 mm				
4	Inspection Done Before Hardening By (Name)				Rev				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		22	3	25				

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA