

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

Check Parameter	Specification	Observations	Remarks
1 Work Order No.		14631	19/66
2 Machined By		N.T.L. H/c Shop	Day No. 1.8.0.6-9
3 Pallet Die No.		14817 (G.O) H/c	Rev. 03
4 Die Category	Drg. No.	H. Jumbo	
5 Out Side Diameter	Drg. No.	680.7mm, Step 002 693mm	Tapper 8°
6 Inside Diameter	Drg. No.	546.12mm (Box. 548.4mm)	Step length 91mm
7 Width of Pellet Die	Drg. No.	195mm	Under cut 2.5mm
8 Grooves as per Drawing	Drg. No.	32.7x9.2mm 32.7x9.2mm (4x2)mm	
9 Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10 Drilling Area Surface Smoothness		OK	2mm Deep Back Side
11 Tapping Operator		H/c Shop	Side
12 Tapping PCD		619mm	Tapping No.
13 Tapping Hole Diameter		H16 - Check by H16 Bolt	of Holes 2
14 Tapping On Second Side	Half pitch of 1st side	OK	Back Side
15 Tapping Hole Depth		Drill Depth 33.4mm	Tapping Depth 31.6
16 Perpendicularity of Tapped Hole		Yes	
17 Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 12/4/25

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 20

1	Counter Sinking Depth & Finish	OK							Row 12
2	External Relief Dia	7.5mm	All Rows						
3	External Relief Depth		47mm						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Ramesh						
6	Material Sent For Hardening On Date		12	4	25				

Inspected By (Sign) & Date

Ravi 12/4/25

Reviewed by (Engineer-CNC)

Manager-QA