



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)

9628

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14630 ✓	33/66 ✓
2	Machined By		V. T. L. n/c Shop	Dr. No. 12.38-9 ✓
3	Pallet Die No.		14812 (G.O) ✓	Rev. 03 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680-7mm Step 00.2693mm, Tapper 8°	
6	Inside Diameter	Drg. No.	546.12mm (Box: 548.4mm) Step length 31mm	
7	Width of Pellet Die	Drg. No.	195mm	Under cut = 2.5mm ✓
8	Grooves as per Drawing	Drg. No.	32x7x9.2mm / 32x7x9.2mm (4x8)mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2mm Deep Bottom
11	Tapping Operator		n/c Shop	Side
12	Tapping PCD		619mm	Tapping No. of Holes = 2
13	Tapping Hole Diameter		W16: Check by W16 Bolt	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4mm	Tapping Depth 31mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 15/4/25	
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				
1	Counter Sinking Depth & Finish	ok		Counter 30°
2	External Relief Dia	7.5mm	All Rows	Row 12
3	External Relief Depth		33mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		15 4 25	
Inspected By (Sign) & Date			Ravi 15/4/25	

Reviewed by (Engineer-CNC)

Manager-QA