



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)

9674

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14631	19/08
2	Machined By		V. T. L. H/c Shop	Dy. No. 12.0.0.9
3	Pallet Die No.		1482.0 (6.0) mm	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm, Step 0.2, 693 mm	Tappet 8°
6	Inside Diameter	Drg. No.	546.12 mm (Bore: 548.4 mm)	Step Length 21 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut 2.5 mm
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 mm / 32.7 x 9.2 mm	(4 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 mm	Tapping H/c
13	Tapping Hole Diameter		H/c Check by H/c Ball	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 mm	Tapping Depth 31
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/4/25

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	7.5 mm		All Round						Rev 12
3	External Relief Depth			47 mm						
4	Inspection Done Before Hardening By (Name)			Ravi						
5	Material Sent For Hardening By (Name)			Lark Furnace						
6	Material Sent For Hardening On Date		19	4	25					

Inspected By (Sign) & Date

Ravi 19/4/25

Reviewed by (Engineer-CNC)

Manager-QA