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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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14830	33/68
2	Machined By		V. T. L. n/c Shop	Dy. M. 18.0.09
3	Pallet Die No.		14814 (6.0) n/c	Rev. 1.0.2
4	Die Category	Drg. No.	M. 7.6.60	
5	Out Side Diameter	Drg. No.	680.7 mm, Step on 693 mm	Tapping 8
6	Inside Diameter	Drg. No.	546.12 mm (Bor. 548.4 mm)	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Width 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	8 mm Reeb
11	Tapping Operator		n/c Shop	Both Side
12	Tapping PCD		619 mm	Tapping H
13	Tapping Hole Diameter		MIS - Check by MIS Bolt	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 33.4 mm
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.

Counter B

1	Counter Sinking Depth & Finish	OK						Row - 12
2	External Relief Dia	4.5 mm		All Rows				
3	External Relief Depth			33 mm				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Purvace				
6	Material Sent For Hardening On Date		19	4	25			

Inspected By (Sign) & Date

Ravi 19/4/25

Reviewed by (Engineer-CNC)

Manager-QA