



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)

9668

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14677	33/70
2	Machined By		M.T.L. H/c Shop	Drill 120.577
3	Pallet Die No.		13547 (8.0) H/c	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 H/c, 31 ch 002 397.8 H/c	Tabber 5°
6	Inside Diameter	Drg. No.	546.12 H/c (Bot. 548.3)	Step length 38.5
7	Width of Pellet Die	Drg. No.	215 H/c	Under cut 21.8 H/c
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 9.15 H/c 29.5 x 10 x 9.15 H/c (6 x 8) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Step 1st Deep Both Side
11	Tapping Operator		H/c Shop	
12	Tapping PCD		618 H/c	
13	Tapping Hole Diameter		H18: Circle by H18 B.11	Tapping H/c of Hole and Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 32.3 H/c	Tapping Depth 30.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sav: 20/4/25	
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° Row 2 12
2	External Relief Dia	9.0 H/c	All Rows	
3	External Relief Depth		37 H/c	
4	Inspection Done Before Hardening By (Name)		Sav!	
5	Material Sent For Hardening By (Name)		Lark Row race	
6	Material Sent For Hardening On Date		20 4 25	
Inspected By (Sign) & Date			Sav: 20/4/25	

Reviewed by (Engineer-CNC)

Manager-QA