



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9683

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.		14703	27/06
2	Machined By		V.T.L. N/A Shop	Dy. M. 28/08
3	Pallet Die No.		14880 (A.O) M	Rev 208
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	880.1 mm	893 mm Tapper 80
6	Inside Diameter	Drg. No.	546.12 mm (Bot. 548.1)	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut 28 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 mm	32 x 7 x 9.1 mm (4 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face side step
11	Tapping Operator		N/A Shop	2 mm Deep Bottom
12	Tapping PCD		619 mm	3.34
13	Tapping Hole Diameter		N/A	Tapping N/A
14	Tapping On Second Side	Half pitch of 1st side	N/A Check by M16 Ball	of holes 2
15	Tapping Hole Depth		Drill Depth 33.3 mm	Tapping Depth 31 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/4/25

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	7.0 mm		All Rows				Row 12
3	External Relief Depth			39 mm				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Rurnace				
6	Material Sent For Hardening On Date		21	4	25			

Inspected By (Sign) & Date

Ravi 21/4/25

Reviewed by (Engineer-CNC)

Manager-QA