



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

9687

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14735	66/66
2	Machined By		V.T.L. n/c Shop	By H.S. 12.0.2009
3	Pallet Die No.		14978(12.0) n/c	Rev. 03
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm Step 00. 893 mm	Tabber 8"
6	Inside Diameter	Drg. No.	546.12 mm (Bot. 548.4 mm)	Step length 3.1 mm
7	Width of Pellet Die	Drg. No.	195 mm	When 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	
10	Drilling Area Surface Smoothness		ok	Face side step
11	Tapping Operator		n/c Shop	2 mm Dash
12	Tapping PCD		619 mm	Both side
13	Tapping Hole Diameter		116.2 Check by 116 Ball	Tapping No
14	Tapping On Second Side	Half pitch of 1st side	ok	of holes - 2 Both side
15	Tapping Hole Depth		Drill Depth 33.4 mm	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sai 22/4/25	
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 60°
2	External Relief Dia		No Relief	Rep. 6
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark Forging	
6	Material Sent For Hardening On Date		22 4 25	
Inspected By (Sign) & Date			Sai 22/4/25	

Reviewed by (Engineer-CNC)

Manager-QA