



Lark Engineering Company (India) Pvt. Ltd.

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

9932

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.		14984	30/06
2	Machined By		V. T. L. H/C Shop	By H. 120.92
3	Pallet Die No.		15144 (6.0) mm	Revised
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm	Step 0.01 893 mm Tapper 8'
6	Inside Diameter	Drg. No.	546.12 mm (Bore 548.14) mm	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut 2.8 mm
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 mm / 32.7 x 9.1 mm (4.0) 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 11
13	Tapping Hole Diameter		H/C - Check by H16 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 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 22/5/25	
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		Caught 30
2	External Relief Dia	7.0 mm	All Round	Round 12
3	External Relief Depth		36 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purwar	
6	Material Sent For Hardening On Date		22 5 25	
Inspected By (Sign) & Date			Ravi 22/5/25	

Reviewed by (Engineer-CNC)

Manager-QA