



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.		14711	33/48/70
2	Machined By		V.T.L H/C Shop	Dry H/C Shop
3	Pallet Die No.		14337 (G.O) H/C	Rev 203
4	Die Category	Drg. No.	H-Jumbo	
5	Out Side Diameter	Drg. No.	688 mm Step OD = 697.7 mm Taper = 5	
6	Inside Diameter	Drg. No.	546.12 mm (1.80) = 548.4 mm Step length = 38.5	
7	Width of Pellet Die	Drg. No.	215 mm	Under Cut = 1.7-8
8	Grooves as per Drawing	Drg. No.	29.5 x 107.9.1 mm / 29.5 x 107.9.1 mm (67.8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	1 mm Deep
11	Tapping Operator		H/C Shop	Both Side
12	Tapping PCD		618 mm	Tapping Ho
13	Tapping Hole Diameter		H/C Shop	of holes = 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 32.4 mm	Tapping Depth 30.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Savi 24/6/25	
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		Count as 30
2	External Relief Dia	6.5 mm / 7.3 mm	6.5 mm	All Rows 2 37 mm
3	External Relief Depth		7.3 mm	All Rows 2 22 mm
4	Inspection Done Before Hardening By (Name)		Savi	
5	Material Sent For Hardening By (Name)		Lark For race	
6	Material Sent For Hardening On Date		24 6 25	
Inspected By (Sign) & Date			Savi 24/6/25	

Reviewed by (Engineer-CNC)

Manager-QA