



Lark Engineering Company (India) Pvt. Ltd.

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

10273

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.		15189	45/60
2	Machined By		V. T. L. H/c Shop	Dr. H. 1.8.0-348
3	Pallet Die No.		15939(8.0)H	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm, Step 00, 798mm	Tabber 2.4
6	Inside Diameter	Drg. No.	660.14mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	323.9mm	Undercut = 9mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping of Holes = 12
12	Tapping PCD		725mm	Both Side
13	Tapping Hole Diameter		H20, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 30.4mm	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rev: 15/7/25	2.51-1
1	As per programme no.			32.1mm width
2	Gun Drilling Work Completed On			8mm Deep
3	Hole Finish In Gun Drilling	Marked	ok	Both Side
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 6
2	External Relief Dia	8.5mm	Outside 8.3-3	Rev: 22
3	External Relief Depth		23mm	Inner 15mm
4	Inspection Done Before Hardening By (Name)		Rev:	
5	Material Sent For Hardening By (Name)		Lark furnace	
6	Material Sent For Hardening On Date		15 7 25	
Inspected By (Sign) & Date			Rev: 15/7/25	

Sat 15/7/25

Reviewed by (Engineer-CNC)

Manager-QA