



Lark Engineering Company (India) Pvt. Ltd.

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

10288

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.			
2	Machined By		15275 ✓	29/60 ✓
3	Pallet Die No.		V.T.L. n/c Shop	Dry H. 12.0.1285
4	Die Category	Drg. No.	15354(2.8)H	Rev. 00
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	780mm ✓ Step on 801mm	Tapper. 9.5°
7	Width of Pellet Die	Drg. No.	680.14mm ✓	Step length = 28mm
8	Grooves as per Drawing	Drg. No.	316mm ✓	Undercut = 10.5mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	18x9x6mm / 18x9x6mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		725mm	
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 = 22.4mm	Tapping Depth = 5mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sav: 17/7/25	
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 - 4 Holes Closed	
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	3.3mm	22.8mm	22.3mm
3	External Relief Depth		34mm	31mm
4	Inspection Done Before Hardening By (Name)		Sav:	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		17	7
Inspected By (Sign) & Date			Sav: 17/7/25	

Reviewed by (Engineer-CNC)

Manager-QA