



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)

10385

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15566	36/47
2	Machined By		V. T. L. n/c Shop	Dr. No. 12.990
3	Pallet Die No.		14573	Rev. no
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	694 mm, Step 002, 693 mm	Tabber 4°
6	Inside Diameter	Drg. No.	600.14 mm	Step length 21 mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	14x8x7 mm / 14x8x7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		640 mm	Tapping 1- of holes 12
13	Tapping Hole Diameter		M20, Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 22.4 mm	Tapping Depth 20.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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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

Counter 60

1	Counter Sinking Depth & Finish	ok							Rev: 29/7/25
2	External Relief Dia	3.5 mm	Outside (3-3)		Inner				
3	External Relief Depth		17 mm		11 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		29	7	25				

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA