



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.		15630	35/66
2	Machined By		V.T.L. H/c Shop	Dr. No. 12.2.32
3	Pallet Die No.		15555 (B.O.)	Carbide Rev = 08
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.2 mm Step 00. 693 mm	Tapper 8°
6	Inside Diameter	Drg. No.	546.14 mm (Bos. 548.2)	Step length. 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut. 2.75
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 mm / 32.7 x 9.1 mm (4 x 8)	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		H/c Shop	Gun Drill
12	Tapping PCD		619 mm	Both Side
13	Tapping Hole Diameter		NIG, Crack by NIG Bolt	Tapping No. of Holes. 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth. 33.7 mm	Tapping Depth 31.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sav: 29/7/25	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK	Counter. 30	
2	External Relief Dia	1.0 mm	All Rnds	
3	External Relief Depth		31 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		29	7 25
Inspected By (Sign) & Date			Sav: 29/7/25	

Sav: 29/7/25

Reviewed by (Engineer-CNC)

Manager-QA