

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.			
2	Machined By		15707	55/66
3	Pallet Die No.		V.T.L. n/c Shop	58/66
4	Die Category	Drg. No.	16087 (10.0) n/c	Qty 4, 12.0.1260 Rev 01
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	680.1 n/c, Step 002, 693 n/c	Tappet 8
7	Width of Pellet Die	Drg. No.	546.14 n/c (1800, 548.2)	Step length 13.3
8	Grooves as per Drawing	Drg. No.	205.6 n/c	Identical 2.7 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	32.3 x 6 x 9.1 n/c 32.3 x 6 x 7.1 n/c (4x8 x 4x8)	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		n/c Shop	2.3 n/c Deep
12	Tapping PCD		619 n/c	Both Side
13	Tapping Hole Diameter		W16, Check by W16 Bolt	Tapping Hole of Hole 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth = 33.6 n/c	Tapping Depth 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 7/8/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		N-	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Count on 8
2	External Relief Dia	11.0 n/c	1st Rad 11.0 n/c	2nd Rad 8 n/c
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		7 8 25	
Inspected By (Sign) & Date			Ravi 7/8/25	

Reviewed by (Engineer-CNC)

Manager-QA