

Lark Engineering Company (India) Pvt. Ltd.

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

10477

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		15544	40/55
3	Pallet Die No.		V.T.L. H/C Shop	Dg No. 1.8.0.2978
4	Die Category	Drg. No.	15576(8.0)H	Rev. 02
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	770 mm, Step 00. 793mm	Tapper 4°
7	Width of Pellet Die	Drg. No.	660.14 mm	Step length 28.3
8	Grooves as per Drawing	Drg. No.	324.6 mm	Under cut 11.5mm
9	Fitting Sizes on CNC Plate	Drg. No.	21.8 x 8 x 8 mm / 21.8 x 8 x 8 mm	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		H/C Shop	0.8 mm Deep
12	Tapping PCD		725 mm	Back Side
13	Tapping Hole Diameter		H20, Check by H20 Bolt	Tapping No
14	Tapping On Second Side	Half pitch of 1st side	ok	of Holes = 16
15	Tapping Hole Depth		Drill Depth 30.4mm	Back Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 28.4
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 14/8/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	
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	9.0mm	outside 24-4)	Inner
3	External Relief Depth		23mm	15mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Burnore	
6	Material Sent For Hardening On Date		14 8 25	
Inspected By (Sign) & Date			Ravi 14/8/25	

Reviewed by (Engineer-CNC)

Manager-QA