



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.		15798	44/06
2	Machined By		V. T. L. N/A Shop	Py No. 18.2.136
3	Pallet Die No.		16088 (8.0) mm	Revol
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm / Step 02: 698 mm	Tappet 8
6	Inside Diameter	Drg. No.	546.14 mm (Bot: 548.2)	Step length 31.3
7	Width of Pellet Die	Drg. No.	205.6 mm	Under cut: 2.8 mm
8	Grooves as per Drawing	Drg. No.	32.3 x 6 x 9.1 mm / 32.3 x 6 x 9.1 mm (4 x 8 x 4 x 8)	Face side Step
9	Fitting Sizes on CNC Plate	Drg. No.	OK	2.3 mm Deep
10	Drilling Area Surface Smoothness		OK	Both Side
11	Tapping Operator		N/A Shop	Tapping
12	Tapping PCD		319 mm	of 18.2.2
13	Tapping Hole Diameter		M16, Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 32.7 mm	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 19/8/25	
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 30°
2	External Relief Dia	9.0 mm	All Rows	Rev 10
3	External Relief Depth		22 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purrace	
6	Material Sent For Hardening On Date		19 8 25	
Inspected By (Sign) & Date			Ravi 19/8/25	

Satya 19/8/25

Reviewed by (Engineer-CNC)

Manager-QA