



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.		15251	60/66
2	Machined By		V. T. L. n/c Shop	Dy. M. L. S. G. 936
3	Pallet Die No.		16199 (3.5)	Rev 01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032 mm, Step 00-1033 mm	Tapping 3"
6	Inside Diameter	Drg. No.	900.14 mm	Step length .32 mm
7	Width of Pellet Die	Drg. No.	375 mm	Load cut .05 mm
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 mm / 29.5 x 8 x 13 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes 15
12	Tapping PCD		970 mm	Both Side
13	Tapping Hole Diameter		124.2 Check by 124.0	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 38.4 mm	Tapping Depth 35.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rev: 20/8/25	2.31.2
1	As per programme no.			32.14 mm hole
2	Gun Drilling Work Completed On			7.5 mm Deep
3	Hole Finish In Gun Drilling	Marked	OK	Both Side
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 59
2	External Relief Dia	4.0 mm	Outer 4.0 mm	
3	External Relief Depth		13 mm	Inner 6 mm
4	Inspection Done Before Hardening By (Name)		Rev:	
5	Material Sent For Hardening By (Name)		Lark Purack	
6	Material Sent For Hardening On Date		20 8 25	
Inspected By (Sign) & Date			Rev: 20/8/25	

Satish 20/8/25

Reviewed by (Engineer-CNC)

Manager-QA