



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.		15526	26/04/105
2	Machined By		V. T. L. n/c Shop	38/46/105
3	Pallet Die No.		16328(6.0) n/c	Dry n/c, 18.7.1190
4	Die Category	Drg. No.	S. Jumbo	Reused
5	Out Side Diameter	Drg. No.	1059.7 mm Step on	1076.9 mm
6	Inside Diameter	Drg. No.	848.1 mm (Bar: 850.4) mm	Tapper: 8°
7	Width of Pellet Die	Drg. No.	265.9 mm	Step length: 42
8	Grooves as per Drawing	Drg. No.	45+8+9.2 mm / 45+8+9.2	Under cut: 3.5 (8+8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		951.9 mm	of holes 2
13	Tapping Hole Diameter		n/c Check by n/c Bar	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 42.4 mm	Tapping Depth: 49.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 29/8/25	
1	As per programme no.			Face Groove
2	Gun Drilling Work Completed On			2 mm Deep Both Side
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	1st Pad	Counter: 30
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm / 7.9 mm	Row: 16
3	External Relief Depth		7.0 mm / 8.1 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purvance	
6	Material Sent For Hardening On Date		29/8/25	
Inspected By (Sign) & Date			Ravi 29/8/25	

Reviewed by (Engineer-CNC)

Manager-QA