

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.		15902	30/66
2	Machined By		V.T.L. H/C Shop	Drg. H. 12.0
3	Pallet Die No.		15627 (G.O.)	Rev. 08
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	380.1 mm	Step 02, 393 mm
6	Inside Diameter	Drg. No.	546.14 mm	(Bore, 548.2) mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut, 2.8 mm
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 mm	(4 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side
10	Drilling Area Surface Smoothness		OK	Step 2 mm
11	Tapping Operator		H/C Shop	Both Side
12	Tapping PCD		619 mm	Tapping Holes
13	Tapping Hole Diameter		H16, Check by H16	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 32.4 mm	Tapping Depth 31
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sai: 30/8/25	
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	7.0 mm	All Bore	Row 1200
3	External Relief Depth		36 mm	
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		30/8/25	
Inspected By (Sign) & Date			Sai: 30/8/25	

Reviewed by (Engineer-CNC)

Manager-QA