

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.		18001	33/66
2	Machined By		V. T.L. n/c Shop	Dr H. 180.8-9
3	Pallet Die No.		15563(B.O) n/c	Rev 103
4	Die Category	Drg. No.	M. Jumbo	creatures
5	Out Side Diameter	Drg. No.	680.7 mm	Step 00. 693 mm
6	Inside Diameter	Drg. No.	546.12 mm	Boz. 548.4 mm
7	Width of Pellet Die	Drg. No.	195 mm	Tapper. 8°
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm	Step length. 31 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.2 mm	Id cent. 2.5 mm
10	Drilling Area Surface Smoothness		ok	(4 x 8) mm
11	Tapping Operator		ok	Race Side
12	Tapping PCD		n/c Shop	2 mm Gap
13	Tapping Hole Diameter		619 mm	Both Side
14	Tapping On Second Side	Half pitch of 1st side	H16 Check by H16 Ball	Tapping No
15	Tapping Hole Depth		ok	of holes 2
16	Perpendicularity of Tapped Hole		Drill Depth. 33.4 mm	Both Side
17	Visual Inspection Before Gun Drilling		yes	Tapping Depth 31.8
			ok	

Inspected By (Sign) & Date

Ravi 12/9/25

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	7.5 mm		All Rows				Row 12
3	External Relief Depth			33 mm				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		12	9	25			

Inspected By (Sign) & Date

Ravi 12/9/25

Reviewed by (Engineer-CNC)

Manager-QA