



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10660

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.		15747	50/60
2	Machined By		V.T.I. M/c Shop	55/60
3	Pallet Die No.		15331 (8.0) M	Dry No. 1st-320
4	Die Category	Drg. No.	M/Jumbo	(Rev 08)
5	Out Side Diameter	Drg. No.	680.1 M	Step 00: 692.9 M Tapper 8"
6	Inside Diameter	Drg. No.	548.14 M (Rev: 548.2)	Step length = 31 M
7	Width of Pellet Die	Drg. No.	195 M	Under cut = 2.8 M
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 M	(4 x 8) M
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face side Step
11	Tapping Operator		M/c Shop	Both Side
12	Tapping PCD		619 M	Tapping No
13	Tapping Hole Diameter		HIG: Check by HIG B-11	of Hole: 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill depth = 33.6 M	Tapping depth = 31.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi	16/9/25
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 M	1st Pad	16 M	2nd Pad	11 M	Row-12
3	External Relief Depth						
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date						16 9 25
Inspected By (Sign) & Date							Ravi 16/9/25

Reviewed by (Engineer-CNC)

Manager-QA