



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.		14345	62/68
2	Machined By		V.T.L. H/c Shop	Dig Hole 1.3.0 60°
3	Pallet Die No.		14555 (9.0) H/c	Rev 03
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm, Step 00-693 mm	Step length 31 mm
6	Inside Diameter	Drg. No.	546.12 mm (Bar - 548.4 mm)	Tappers 2
7	Width of Pellet Die	Drg. No.	195 mm	Outer cote 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.2 mm	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		H/c Shop	2 mm Deep Hole
12	Tapping PCD		619 mm	Side
13	Tapping Hole Diameter		H16 Check by H16 Bolt	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	ok	of holes 2
15	Tapping Hole Depth		Drill Depth 33.2 mm	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 31.4 mm
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/3/25

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							Rev 60°
2	External Relief Dia	10.0 mm							Rev 8
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

Ravi 15/3/25

Reviewed by (Engineer-CNC)

Manager-QA