



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.		1487-2 ✓	35/5/66
2	Machined By		V.T.L. H/c Shop	32
3	Pallet Die No.		14871(60) H/c	Rev. 08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/c	Step 02: 693 H/c
6	Inside Diameter	Drg. No.	546.12 H/c (Bar - 548.1 H/c)	Tabber 8"
7	Width of Pellet Die	Drg. No.	195 H/c	Step length 6.3 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c 32 x 7 x 9.1 H/c (4 x 8) H/c	Under cut = 2.8 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	8 H/c Deep Rnd
11	Tapping Operator		H/c Shop	Side
12	Tapping PCD		619 H/c	Tapping No
13	Tapping Hole Diameter		H16, Check by H16 Bolt	of holes - 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth - 33.4 H/c	Tapping Depth = 31.6 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 6/5/25	
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		Consistent 30
2	External Relief Dia	6.5 H/c 7.0 H/c	6.5 H/c All Rnds ± 31 H/c	Rnds 12
3	External Relief Depth		7.0 H/c All Rnds ± 18 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Engineering	
6	Material Sent For Hardening On Date		6 5 25	
Inspected By (Sign) & Date			Ravi 6/5/25	

Reviewed by (Engineer-CNC)

Manager-QA