



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.		14382 ✓	28/36/105
2	Machined By		V.T.L. H/c Shop	38/48/105
3	Pallet Die No.		14756 (G.O) H/c	B. Drg. 430-1190
4	Die Category	Drg. No.	S. Jumbo	Rev 00
5	Out Side Diameter	Drg. No.	1059.7 H/c	Step 0.0, 1077 H/c
6	Inside Diameter	Drg. No.	846.12 H/c / 848.5 H/c (1.8mm 85mm)	Step length 4.0 H/c
7	Width of Pellet Die	Drg. No.	266 H/c	Under cut 3.5 H/c
8	Grooves as per Drawing	Drg. No.	45x8x10.2 H/c / 45x8x9.2 H/c	(8x8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side Step 3 H/c
11	Tapping Operator		H/c Shop	Deep Both Side
12	Tapping PCD		952 H/c	Tapping No.
13	Tapping Hole Diameter		H202 Check by H20 Ball	of Hole 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 48.2 H/c	Tapping Depth 40.8 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 15/8/25

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	1.0 H/c / 1.5 H/c	1st Rad	1.0 H/c All Rows 27 H/c	2nd Rad	1.0 H/c All Rows 26 H/c				Row 16
3	External Relief Depth		1.0 H/c All Rows 27 H/c	1.5 H/c All Rows 29 H/c	1.5 H/c All Rows 29 H/c					
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 15/8/25

Reviewed by (Engineer-CNC)

Manager-QA