

Lark Engineering Company (India) Pvt. Ltd.

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

Inprocess Inspection (Pellet Dies)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14502	91/40
2	Machined By		V.T.L. H/O Shop	Dy No. 18.9.91
3	Pallet Die No.		13992 (2.8) H	Rev. of
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5mm H, Step on 499 H	Step length H
6	Inside Diameter	Drg. No.	4.80-12 H	Tappet 12°
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H / 12 x 8 x 3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		454 H	
13	Tapping Hole Diameter		0.94" 2 Check by 0.34" Ball	Tapping H/O of Holes 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.2 H	Tapping Depth 8.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Saw: 21/7/25	
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 60°
2	External Relief Dia	3.3 H	Outside 2.25	Inner
3	External Relief Depth		2.2 H	1.9 H
4	Inspection Done Before Hardening By (Name)		Saw	
5	Material Sent For Hardening By (Name)		Lark Porroce	
6	Material Sent For Hardening On Date		2 4 25	
Inspected By (Sign) & Date			Saw: 21/7/25	

Reviewed by (Engineer-CNC)

Manager-QA