



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.		14737	53/58
2	Machined By		V.T.L. H/c Shop	Dr. H. L. R. G. 98
3	Pallet Die No.		14565 (3.8) mm	Rev. 200
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	77.6 mm	Step 00 = 800 mm
6	Inside Diameter	Drg. No.	66.0 mm	Step length = 12 mm
7	Width of Pellet Die	Drg. No.	315.9 mm	
8	Grooves as per Drawing	Drg. No.	20 x 8 x 7.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		78.5 mm	Tapping H/c of H/c. 12
13	Tapping Hole Diameter		H20. Crack by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 85.4 mm	Tapping Depth = 83.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sav: 21/4/25	
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 - 2 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter, G. Sav = 57
2	External Relief Dia	4.3 mm	Outside 3.8 mm	Inner 5 mm
3	External Relief Depth		12 mm	
4	Inspection Done Before Hardening By (Name)		Sav:	
5	Material Sent For Hardening By (Name)		Lark Rorace	
6	Material Sent For Hardening On Date		21 4 25	
Inspected By (Sign) & Date			Sav: 21/4/25	

Reviewed by (Engineer-CNC)

Manager-QA