



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.		14715	98/98/60
2	Machined By		V.T.L. H/c Shop	Dy No. 18.7.27
3	Pallet Die No.		14199 (4.0) H/c	Rev: 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/c	Step length 98.5
6	Inside Diameter	Drg. No.	660.2 H/c / 660.3 H/c	Under cut = 8 H/c
7	Width of Pellet Die	Drg. No.	324 H/c	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8.1 H/c / 21.5 x 8 x 8.1 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of holes = 12 Both Side
12	Tapping PCD		725 H/c	
13	Tapping Hole Diameter		H/c = Check by H/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 31.4 H/c	Tapping Depth 29.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rao: 28/4/25	
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 30
2	External Relief Dia	4.8 H/c / 5.0 H/c	4.8 H/c	Rev: 42
3	External Relief Depth		5.0 H/c	All Rows = 32 H/c
4	Inspection Done Before Hardening By (Name)			All Rows = 28 H/c
5	Material Sent For Hardening By (Name)			Rao
6	Material Sent For Hardening On Date		28	4
Inspected By (Sign) & Date			Rao: 28/4/25	

Reviewed by (Engineer-CNC)

Manager-QA