



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.		15528	4/66
2	Machined By		V.T.L. H/C Shop	28/66
3	Pallet Die No.		15301 (G.O) H/C	Drill 11.19.0.320
4	Die Category	Drg. No.	H. Jomho	R.008
5	Out Side Diameter	Drg. No.	680.1 mm	Step on. 692.8 mm Tapper. 8"
6	Inside Diameter	Drg. No.	546.14 mm (Bore = 548.2)	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	End cut 8.7 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 mm 32 x 7 x 9.1 mm (4 x 8)	Face Side
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Step 2nd Side
10	Drilling Area Surface Smoothness		OK	Both Side
11	Tapping Operator		H/C Shop	Tapping No
12	Tapping PCD		619 mm	of 1st side
13	Tapping Hole Diameter		H16. Check by H16 Bit	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	Tapping Depth 31.2
15	Tapping Hole Depth		Drill Depth = 33.7 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/7/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
4	Defective Holes (If Any)		OK

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	7.0 mm	1st Pad	2nd Pad				R.0012
3	External Relief Depth		26 mm	28 mm				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		25	7	25			

Inspected By (Sign) & Date

Ravi 25/7/25

Reviewed by (Engineer-CNC)

Manager-QA