



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.		13303 ✓	35/45/55
2	Machined By		V. T.L M/c Shop	Dy No. 1.3.0.1030
3	Pallet Die No.		13865 (60) M4 ✓	Rev. 00
4	Die Category	Drg. No.	M. Jamba ✓	
5	Out Side Diameter	Drg. No.	710 M4 ✓	Step OD. 692 M4 ✓
6	Inside Diameter	Drg. No.	600.12 M4 ✓	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 M4 ✓	
8	Grooves as per Drawing	Drg. No.	36x1.2 7 M4 / 36x1.2 7 M4 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		645 M4 ✓	Tapping No. of Holes. 12 Bo to Side
13	Tapping Hole Diameter		M20 ✓	
14	Tapping On Second Side	Half pitch of 1st side	Check by M20 Bolt ✓	
15	Tapping Hole Depth		Drill Depth. 20.4 M4 ✓	Tapping Depth. 18.6 M4 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/11/24

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

Counter. 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 M4 / 7.0 M4	6.5 M4	All Rows	2 20 M4				
3	External Relief Depth		7.0 M4	All Rows	2 10 M4				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		25	11	24				

Inspected By (Sign) & Date

Ravi 25/11/24

Reviewed by (Engineer-CNC)

Manager-QA