



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.		13653	36/45
2	Machined By		V.T.L. N/A. Shop	Qty No. 1-22-1826
3	Pallet Die No.		13125 (3.0) H4	Rev. 00
4	Die Category	Drg. No.	SEP	
5	Out Side Diameter	Drg. No.	51.0 H4, Step OD = 49.1 H4	Step length 17.5
6	Inside Diameter	Drg. No.	49.0 ± 0.12 H4	
7	Width of Pellet Die	Drg. No.	18.2 H4	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H4 / 12 x 8 x 3 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A. Shop	Tapping Holes of Hole, 8 Back Side
12	Tapping PCD		456 H4	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.2 H4	Tapping Depth 16.6 H4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/12/24

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	13.5 H4	Outside (2-2)		Inner				
3	External Relief Depth	/	15 H4		9 H4				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		24	12	24				

Inspected By (Sign) & Date

Ravi 24/12/24

Sat 24/12/24

Reviewed by (Engineer-CNC)

Manager-QA