



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9062

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.		13909 ✓	42/50 ✓
2	Machined By		V.T.L. M/c Shop	Drg No. 13.02-18
3	Pallet Die No.		13190 (6.0) M4 ✓	Rev. 02 ✓
4	Die Category	Drg. No.	Ø 38 H7	
5	Out Side Diameter	Drg. No.	519.7 M4 Step OD: 491 M4	Step length: 17.5
6	Inside Diameter	Drg. No.	420.12 M4 ✓	
7	Width of Pellet Die	Drg. No.	182 M4 ✓	
8	Grooves as per Drawing	Drg. No.	12x 8x 3 M4 / 12x 8x 3 M4 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No. of Holes: 8 Both Side
12	Tapping PCD		454 M4 ✓	
13	Tapping Hole Diameter		M20: Check by M20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.3 M4	Tapping Depth: 16.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24/1/25

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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter: 60
2	External Relief Dia	6.5 M4	Outside (3-3)	Inner				Row: 18
3	External Relief Depth		14 M4	8 M4				
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	1	25			

Inspected By (Sign) & Date

Ravi 24/1/25

Suresh 24/1/25

Reviewed by (Engineer-CNC)

Manager-QA