



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.		13976	45/45
2	Machined By		V.T.L. N/C Shop	
3	Pallet Die No.		13887 (6.0) H4	Dy No. 13.02 135 Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4.05 H4	
6	Inside Diameter	Drg. No.	Step O.D. 39.5 H4	Step length 9.5
7	Width of Pellet Die	Drg. No.	315.12 H4	
8	Grooves as per Drawing	Drg. No.	118 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	9.5 x 7 x 3 H4	9.5 x 7 x 3 H4
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/C Shop	Tapping No. of Holes = 8 Both Side
13	Tapping Hole Diameter		356 H4	
14	Tapping On Second Side	Half pitch of 1st side	03/4" = Check by 03/4" Ball ok	
15	Tapping Hole Depth		Drill Depth 18.3 H4	Tapping Depth 16.5 H4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sai 17/2/25

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 6
2	External Relief Dia	6.5 H4	Outside (2-2)	Inner			Rev. 10
3	External Relief Depth		5 H4	Nil			
4	Inspection Done Before Hardening By (Name)						Sai
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		17	2	25		

Inspected By (Sign) & Date

Sai 17/2/25

Reviewed by (Engineer-CNC)

Manager-QA