



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.		14155	45/50
2	Machined By		V.T.L. N/C Shop	Drg No. 13.0.44
3	Pallet Die No.		14258 (8.0) M4	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.5 M4	Step length 13.5
6	Inside Diameter	Drg. No.	420.4 M4	
7	Width of Pellet Die	Drg. No.	159 M4	
8	Grooves as per Drawing	Drg. No.	7x7x5 M4	
9	Fitting Sizes on CNC Plate	Drg. No.	7x7x5 M4	
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		455 M4	
14	Tapping On Second Side	Half pitch of 1st side	0.36" = Check by 0.36" Bolt	
15	Tapping Hole Depth		ok	Drill Depth 22.3 M4 Tapping Depth 20.7 M4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 18/2/25	
1	As per programme no.			2 Slot Down width 7 M4 Deep Both Side
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	8.5 M4	outside (2.2)	Row = 12
3	External Relief Depth		13 M4	
4	Inspection Done Before Hardening By (Name)		Inner 5 M4	
5	Material Sent For Hardening By (Name)		Ravi	
6	Material Sent For Hardening On Date		Lark Porroce	
Inspected By (Sign) & Date			Ravi 18/2/25	

Reviewed by (Engineer-CNC)

Manager-QA