



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.		14028	30/47
2	Machined By		N/C Shop	Drg No. 12518 (3.0) H4
3	Pallet Die No.		12518 (3.0) H4	Rev. 00
4	Die Category	Drg. No.	2x2 outside	
5	Out Side Diameter	Drg. No.	614 H4	Step 00, 612 H4
6	Inside Diameter	Drg. No.	520.12 H4	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	13x8x5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H4	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		565 H4	Tapping No. of Holes 12 Both Side
13	Tapping Hole Diameter		H2 - Check by H2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 H4	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ins: 19/2/25

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 = 60
2	External Relief Dia	3.5 H4	Outside (2-3)		Inner		Rev. 00
3	External Relief Depth		20 H4		17 H4		
4	Inspection Done Before Hardening By (Name)						Ins: 19/2/25
5	Material Sent For Hardening By (Name)						Lark Porroce
6	Material Sent For Hardening On Date		19	2	25		

Inspected By (Sign) & Date

Ins: 19/2/25

Reviewed by (Engineer-CNC)

Manager-QA