



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14215	410/50
2	Machined By		V.T.L. N/C Shop	Drg No. 1.2.02-29995
3	Pallet Die No.		13875 (4.0) H4	Rev = 00
4	Die Category	Drg. No.	HJ410	
5	Out Side Diameter	Drg. No.	700 H4, Step OD, 703 H4	Step length 24 H4
6	Inside Diameter	Drg. No.	600.12 H4	Tapbers 4°
7	Width of Pellet Die	Drg. No.	265 H4	Undercut = 1.5 H4
8	Grooves as per Drawing	Drg. No.	15x8x7.1 H4 15x8x7.2 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		640 H4	Tapping No of holes 16 Both side
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 20.3 H4	Tapping Depth 18 H4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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	4.5 H4	Outside (3-3)		Inner			Rows 38
3	External Relief Depth		14 H4		10 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		19	2	25			

Inspected By (Sign) & Date

Ravi 19/2/25

Satish 19/2/25

Reviewed by (Engineer-CNC)

Manager-QA