



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.		14360	80/25/66
2	Machined By		V.T.L. n/a Shop	23/66
3	Pallet Die No.		14734 (6.0) H4	30/25/66
4	Die Category	Drg. No.	H. Jumbo	Rev. 08
5	Out Side Diameter	Drg. No.	680.1 H4 / Step 00: 693.1 H4	Tapper = 3
6	Inside Diameter	Drg. No.	546.12 H4 (Bot 2 548.1 H4)	Step length = 31.4 H4
7	Width of Pellet Die	Drg. No.	195 H4	Under cut = 2.8 H4
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H4 32 x 7 x 9.1 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Face Side Step]
11	Tapping Operator		nk Shop	2 H4 Deep Bot
12	Tapping PCD		619 H4	Side
13	Tapping Hole Diameter		H16 2	Tapping No
14	Tapping On Second Side	Half pitch of 1st side	ok	of Hole. 2
15	Tapping Hole Depth		Drill Depth = 33.2 H4	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth = 31.4
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 15/3/25

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, 30
2	External Relief Dia	6.5 H4 / 7.0 H4	1st Pad	6.5 H4 / 7.0 H4	2nd Pad	6.5 H4 / 7.0 H4	3rd Pad	6.5 H4 / 7.0 H4	4th Pad	6.5 H4 / 7.0 H4
3	External Relief Depth									
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date

Sasi 15/3/25

Reviewed by (Engineer-CNC)

Manager-QA