



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.		14560	57/66
2	Machined By		N.C. Shop	Day No. 1.8.0230
3	Pallet Die No.		14771 (10.0) M4	Rev 208
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 M4, Step OD = 693 M4	Tappet 8°
6	Inside Diameter	Drg. No.	546.12 M4 (Bar = 548.4)	Step length 31 M4
7	Width of Pellet Die	Drg. No.	195 M4	Under cut = 2.8 M4
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 M4 32 x 7 x 9.1 M4 (4 x 8) M4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 M4 Deep
11	Tapping Operator		N.C. Shop	Both Side
12	Tapping PCD		619 M4	Tapping No.
13	Tapping Hole Diameter		M16, Check by M16 Bolt	of holes, 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.2 M4	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 27/3/25

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

Counter 60

1	Counter Sinking Depth & Finish	OK						Row = 8
2	External Relief Dia	11.0 M4		All Rows				
3	External Relief Depth			9 M4				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Romance				
6	Material Sent For Hardening On Date		27	3	25			

Inspected By (Sign) & Date

Ravi 27/3/25

Reviewed by (Engineer-CNC)

Manager-QA