

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.		14580	22/40
2	Machined By		V.T.L. n/c Shop	Qty 12.0.942
3	Pallet Die No.		14478(2.8) 4H	Rev. 00
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	600 4H, Step 002 601.5 4H	Tapping 12°
6	Inside Diameter	Drg. No.	580.12 4H	Step length 21.5
7	Width of Pellet Die	Drg. No.	222 4H	Undercut 5.70 4H
8	Grooves as per Drawing	Drg. No.	13x8x5 4H 13x8x5 4H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes of holes 12° Both Side
12	Tapping PCD		565 4H	
13	Tapping Hole Diameter		1202 Check by 425 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 4H Tapping 12° 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rev: 5/4/25	
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		
2	External Relief Dia	3.1 4H	All Rows	
3	External Relief Depth		18 4H	
4	Inspection Done Before Hardening By (Name)		Rev:	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		5 4 25	
Inspected By (Sign) & Date			Rev: 5/4/25	

Reviewed by (Engineer-CNC)

Manager-QA