



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)

10214

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14976	60/65
2	Machined By		V.T.L. H/O Shop	Dr. H. 18.0 951
3	Pallet Die No.		15821 (4.5) M4	Revised
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	550 M4	Step length 17.5
6	Inside Diameter	Drg. No.	42.14 M4	
7	Width of Pellet Die	Drg. No.	158 M4	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 M4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		454 M4	Tapping H/O of Holes: 8 Both Side
13	Tapping Hole Diameter		M2, Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.7 M4	Tapping Depth 16.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Signature: 4/7/25

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	5.0 M4	Outside 25-25	Inner				Rev 2 18
3	External Relief Depth		14 M4	5 M4				
4	Inspection Done Before Hardening By (Name)							Signature
5	Material Sent For Hardening By (Name)							Lark Purchase
6	Material Sent For Hardening On Date		4	7	25			

Inspected By (Sign) & Date

Signature: 4/7/25

Reviewed by (Engineer-CNC)

Manager-QA