



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.			
2	Machined By		15432 ✓	35/40/66
3	Pallet Die No.		V. T. L. n/c Shop	Dry H. 18.0. 609
4	Die Category	Drg. No.	15205 (6.0) H4	Rec. 03
5	Out Side Diameter	Drg. No.	N. 70mm ho	44x3
6	Inside Diameter	Drg. No.	680.7 H4	Step 00. 692.7 H4
7	Width of Pellet Die	Drg. No.	546.4 H4 (Box: 548.4 H4)	Step length 31 H4
8	Grooves as per Drawing	Drg. No.	195 H4	12den cut 28.5 H4
9	Fitting Sizes on CNC Plate	Drg. No.	32x7x9.2 H4 32x7x9.2 H4 (4x8) H4	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		OK	2nd Drap Bottom
12	Tapping PCD		H4C Shop	Side
13	Tapping Hole Diameter		619 H4	Tapping H4
14	Tapping On Second Side	Half pitch of 1st side	H4G2 Check by H4G Roll	g Holes 2
15	Tapping Hole Depth		OK	Bottom Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.6 H4	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Rev: 22/7/25

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								Count en 39
2	External Relief Dia	6.5 H4 / 7.0 H4	6.5 H4	All Rows 231 H4						Rev. 12
3	External Relief Depth		7.0 H4	All Rows 86 H4						
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		22	7	25					

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA