

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.		15976	50/66
2	Machined By		V.T.L M/c Shop	Dry No 2 320
3	Pallet Die No.		15332 (8.0) H4	Revised 28
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H4	Step OD = 693 H4 Tapped 8°
6	Inside Diameter	Drg. No.	546.14 H4 (Box 548.2)	Step length 31 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	C 4 x 2 H4
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	9 H4 Deep Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		319 H4	of Holes 22
13	Tapping Hole Diameter		H16 Check by H16 B-1	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 2 33.4 H4	Tapping depth 2 31.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 22/9/25

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 2 30°
2	External Relief Dia	9.0 H4						Row 215
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

Ravi 22-9-25

Reviewed by (Engineer-CNC)

Manager-QA