



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.		16038	32/40
2	Machined By		V.T.I. M/c Shop	Dry No 2 Lark 2810
3	Pallet Die No.		13529(4.0) H4	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4 mm H4	Step OD = 394.9 H4
6	Inside Diameter	Drg. No.	320.14 H4	Step length 14.5
7	Width of Pellet Die	Drg. No.	142 H4	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H4 / 15.5 x 7 x 2 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		355 H4	of Holes = 8
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 H4	Tapping depth = 218.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/9/25

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 = 60
2	External Relief Dia	4.5 H4	Outside 2.25		Inner				Row = 16
3	External Relief Depth		12 H4		8 H4				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark furnace				
6	Material Sent For Hardening On Date				23	9	25		

Inspected By (Sign) & Date

Ravi 23-9-25

Reviewed by (Engineer-CNC)

Manager-QA