



# 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.		11040	40/50
2	Machined By		V.T.L. N/C Shop	Dr. No. L.F.C. 175-1
3	Pallet Die No.		9986 (4.0) H4	Rev=01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	700 H4 Step OD: G92.8 H4 Tapper: 12"	
6	Inside Diameter	Drg. No.	600.12 H4	Step length: 19.8 H4
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	12x8x7 H4 / 12x8x7 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		640 H4	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 H4	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 12/1/24

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	U.5 H4	Outside (2-3)	Inner			Ratio = 32
3	External Relief Depth		14 H4	10 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		12	1	24		

**Inspected By (Sign) & Date**

Ravi 12/1/24

Reviewed by (Engineer-CNC)

Manager-QA