



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.		11571	38/50
2	Machined By		V. T. G. N/C Shop	Dy. M. Lark 8752
3	Pallet Die No.		11403 (4.0) M4	
4	Die Category	Drg. No.	39970	
5	Out Side Diameter	Drg. No.	6.20 M4, Step 0.2, 6.12 M4, Step length 9.4	
6	Inside Diameter	Drg. No.	5.20.12 M4	
7	Width of Pellet Die	Drg. No.	186 M4	
8	Grooves as per Drawing	Drg. No.	13x8x5 M4 13x8x5 M4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping M4 of holes 12 Both Side
12	Tapping PCD		565 M4	
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 20.8 M4 Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/3/24

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					Count on 265
2	External Relief Dia	4.5 M4	Outside (3-3)	Inner			Ravi 25
3	External Relief Depth		16 M4	12 M4			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Forncel
6	Material Sent For Hardening On Date		29	3	24		

Inspected By (Sign) & Date

Ravi 29/3/24

Satya 29/3/24

Reviewed by (Engineer-CNC)

Manager-QA