



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16094	33/50
2	Machined By		V.T.L M/c Shop	Dry No. 6354
3	Pallet Die No.		15686 (3.0) H4	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	619.9 H4	Step OD = 611.9 H4
6	Inside Diameter	Drg. No.	520.14 H4	Step length = 19.8 H4
7	Width of Pellet Die	Drg. No.	222.6 H4	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	15.3 x 8 x 5 H4	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	
13	Tapping Hole Diameter		58.5 H4	
14	Tapping On Second Side	Half pitch of 1st side	H20.2 Check by H20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 20.4 H4	
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi 20/9/25
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 260
2	External Relief Dia	3.5 H4	Outside (3-3)		Inner			Row 2 38
3	External Relief Depth		23 H4		17 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			20	9	25		
Inspected By (Sign) & Date			Ravi 20/9/25					

Reviewed by (Engineer-CNC)

Manager-QA