



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.		13977	35/50 ✓
2	Machined By		V.T.L. H/C Shop	Drg No. Lark 3310
3	Pallet Die No.		11G70 (2.8) H/C	
4	Die Category	Drg. No.	Card inside	
5	Out Side Diameter	Drg. No.	619.8 H/C	Stop 002 611.8 H/C
6	Inside Diameter	Drg. No.	530.12 H/C	Stop length 19.5
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of Holes 12 Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 2.3 H/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 13/1/25	
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 - 1 Hole Closed (2)	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter = 60°				
1	Counter Sinking Depth & Finish	ok		80° - 40°
2	External Relief Dia	3.1 H/C	Outside (2.3-3)	Inner
3	External Relief Depth		2.1 H/C	1.5 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		13	1 25
Inspected By (Sign) & Date			Ravi 13/1/25	

Reviewed by (Engineer-CNC)
 13/1/25

Manager-QA