



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)

8962

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13837	40/50/6055
2	Machined By		V.T.L. n/c Shop	Digital Lark 3510
3	Pallet Die No.		13703(4.0)H	
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	620H, Step 002 612H	Step length 13.5
6	Inside Diameter	Drg. No.	520.4H	
7	Width of Pellet Die	Drg. No.	222H	
8	Grooves as per Drawing	Drg. No.	13x8x5H 13x8x5H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565H	[Tapping No. of holes = 12 Rota Side]
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 20.2H	Tapping Depth 18.6H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/1/25

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

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	4.5H	outside (3-3)		Inner			Row 2-31
3	External Relief Depth		14H		10H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		10	1	25			

Inspected By (Sign) & Date

Ravi 10/1/25

Satyam 10/1/25

Reviewed by (Engineer-CNC)

Manager-QA