



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.		13915	40/50
2	Machined By		V.T.L. N/C Shop	Drg No. Lark 8310
3	Pallet Die No.		13061 (3.5) H4	
4	Die Category	Drg. No.	33310	
5	Out Side Diameter	Drg. No.	619.9 H4	Step OD = 611.9 H4
6	Inside Diameter	Drg. No.	520.12 H4	Step length 19.5
7	Width of Pellet Die	Drg. No.	186 H4	
8	Grooves as per Drawing	Drg. No.	1308x5 H4	1308x5 H4
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		565 H4	Tapping No. of holes 12 Both Side
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 20.2 H4	Tapping Depth 18.6 H4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/1/25

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

Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0 H4	60 Side (3-3)		Inner				
3	External Relief Depth		17 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		11	1	25				

Inspected By (Sign) & Date

Ravi 11/1/25

Reviewed by (Engineer-CNC)

Manager-QA