



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.		13924 ✓	39150 / 6355
2	Machined By		V.T.L. n/c Shop	Dy. n/c Lark 370
3	Pallet Die No.		13396 (3.5) ✓	
4	Die Category	Drg. No.	extraxide	
5	Out Side Diameter	Drg. No.	619.9 ✓ Step 00 = 612 ✓	Step length = 19.5
6	Inside Diameter	Drg. No.	520.12 ✓	
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 ✓ 13x8x5 ✓	
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 ✓	Tapping No of holes = 12 Both 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 = 20.2 ✓ Tapping Depth = 18.8 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rasi 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

Counter = 60

1	Counter Sinking Depth & Finish	ok							Rasi 35
2	External Relief Dia	4.0 ✓	Outside (3-3)		Inner				
3	External Relief Depth		18 ✓		11 ✓				
4	Inspection Done Before Hardening By (Name)								Rasi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		10	1	25				

Inspected By (Sign) & Date

Rasi 10/1/25

Rasi 10/1/25

Reviewed by (Engineer-CNC)

Manager-QA