



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.		13920	50/50
2	Machined By		V. T. L. N/C Shop	6355 Dy. M. Lark
3	Pallet Die No.		13718(4.0) H4	
4	Die Category	Drg. No.	Partside	
5	Out Side Diameter	Drg. No.	619.9 H4	Step Dia 619 H4 Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H4	
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	13x8x5 H4 13x8x5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping H4 of holes 12 Both Side
12	Tapping PCD		565 H4	
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 H4 Tapping Depth 186	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/125

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 Go

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.5 H4	outside (2-3)		Inner				
3	External Relief Depth		4 H4		Will				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Royance				
6	Material Sent For Hardening On Date		11		1	25			

Inspected By (Sign) & Date

Ravi 11/125

Reviewed by (Engineer-CNC)
S. S. 13/11/25

Manager-QA