



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.		13809	40/40/595
2	Machined By		V.T.L M/C Shop	Dy. Hr. Lark 3219
3	Pallet Die No.		13046 (5.0)mm	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm, Step 00 = 491mm	Step length = 17.4
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	10x8x3 mm 18x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	[Tapping No. of Holes = 8 Both Side]
12	Tapping PCD		454 mm	
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 18.2 mm Tapping Depth 16.6 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/1/25

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	5.5mm	outside (2-2)		Inner			Row = 17
3	External Relief Depth		5mm		Mill			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		18	1	25			

Inspected By (Sign) & Date

Ravi 18/1/25

Reviewed by (Engineer-CNC)
18/1/25

Manager-QA