



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.		13962	94/40
2	Machined By		V.T.C. n/a Shop	Dykes Lark 3570
3	Pallet Die No.		13191 (3.5) n/a	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 n/a	Step OD, 395 n/a
6	Inside Diameter	Drg. No.	320.12 n/a	Step length 14.5
7	Width of Pellet Die	Drg. No.	142 n/a	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 n/a / 15.5 x 7 x 2 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	Tapping No. of Holes: 8 Both Side
12	Tapping PCD		355 n/a	
13	Tapping Hole Diameter		M16 Check by M16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.2 n/a	Tapping Depth: 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 24/1/25	
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 Ravi 18
2	External Relief Dia	4.0 n/a	Outside (2-25)	Inner
3	External Relief Depth		20 n/a	16 n/a
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purrace	
6	Material Sent For Hardening On Date		94	1 25
Inspected By (Sign) & Date			Ravi 24/1/25	

Reviewed by (Engineer-CNC)

Manager-QA