



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)

9068

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13996 ✓	40/40 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. Lark 3310
3	Pallet Die No.		12716 (4.0) n/c ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9 n/c ✓	Step OD: 491 n/c
6	Inside Diameter	Drg. No.	420.12 n/c ✓	Step length: 17.4 ✓
7	Width of Pellet Die	Drg. No.	158 n/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x3x3 n/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes: 8 Both Side
12	Tapping PCD		454 n/c ✓	
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 n/c	Tapping Depth: 18.6 n/c
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						Counters: 60
2	External Relief Dia	4.3 n/c	outside (2.2)		Inner			Row: 20
3	External Relief Depth		4 n/c		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		24		25			

Inspected By (Sign) & Date

Ravi 24/1/25

Satya 24/1/25

Reviewed by (Engineer-CNC)

Manager-QA