



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.		INV ✓	44/50 / 6355
2	Machined By		V.T.L. N/C. Shop	Dy. No. Lark 2015
3	Pallet Die No.		13737 (4.0) N/C ✓	
4	Die Category	Drg. No.	Extr. side	
5	Out Side Diameter	Drg. No.	62mm Step OD = 612mm Step length. 19.5mm	
6	Inside Diameter	Drg. No.	52.12mm / 52.14mm (2)	
7	Width of Pellet Die	Drg. No.	222mm ✓	
8	Grooves as per Drawing	Drg. No.	137875mm / 137875mm ✓	
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 - 12 Both Side
12	Tapping PCD		565mm ✓	
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. 20.3mm Tapping Depth. 18mm	
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

Counter 60°

1	Counter Sinking Depth & Finish	OK						Ravi 31
2	External Relief Dia	4.3mm	Outside (3-3)	Inner				
3	External Relief Depth		14mm	6mm				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Fornace
6	Material Sent For Hardening On Date		24	1	25			

Inspected By (Sign) & Date

Ravi 24/1/25

Reviewed by (Engineer-CNC)

Manager-QA