



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)

9/1/13

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14090 ✓	33/40 ✓
2	Machined By		V.T.L. M/c Shop	Dring No. Lark Std
3	Pallet Die No.		13231 (3.0)mm ✓	319B ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9 mm step OD . 490.9 mm ✓	
6	Inside Diameter	Drg. No.	420.12 mm ✓	Step length . 17.5
7	Width of Pellet Die	Drg. No.	158 mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No of Hols . 8 Both side
12	Tapping PCD		454 mm ✓	
13	Tapping Hole Diameter		M.20 check by M.20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.3mm Tapping Depth . 16.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/1/25

1	As per programme no.		_____	
2	Gun Drilling Work Completed On		_____	Discussed with Meeraj Sir
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No 1 Hole Counter Damage	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK						Counter = 60° Power 24
2	External Relief Dia	3.3mm	outside 2-2		Inner			
3	External Relief Depth		13mm		7mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		29	1	25			

Inspected By (Sign) & Date

Ravi 29/1/25

Subba 20/1/25

Reviewed by (Engineer-CNC)

Manager-QA