



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)

9105

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14073 ✓	37/50/355
2	Machined By		v. T.L. n/c Stop	Dy. Lark 3317
3	Pallet Die No.		13832 13832 (50) ✓	
4	Die Category	Drg. No.	Entrance side	
5	Out Side Diameter	Drg. No.	620.44 / Stop 00. 611.9 mm Stop length 19.5	
6	Inside Diameter	Drg. No.	520.12 mm, (Bar = Tabbar 0.3 mm)	
7	Width of Pellet Die	Drg. No.	222 mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Stop	Tapping Ho of holes 12 Back side
12	Tapping PCD		565 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 20.3 mm Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 30/1/25

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 - 2 Hole Closed

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

Count in Gun

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	5.5 mm	outside (3-3)	Inner					Row = 26
3	External Relief Depth		18 mm	13 mm					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		30	1	25				

Inspected By (Sign) & Date

Ravi 30/1/25

Satyam 30/1/25

Reviewed by (Engineer-CNC)

Manager-QA