



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.		14139 ✓	32/42/50 ✓
2	Machined By		V. T. L n/c Shop	Drg. No. Lark 355/10 ✓
3	Pallet Die No.		13838(4.0) n/c	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	619.9 n/c ✓	Step 001 612 n/c ✓
6	Inside Diameter	Drg. No.	520.12 n/c ✓	Step length 19.5 ✓
7	Width of Pellet Die	Drg. No.	222 n/c ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 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: 12 Back Side
12	Tapping PCD		565 n/c ✓	
13	Tapping Hole Diameter		M20, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 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 7/2/25

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 Box

1	Counter Sinking Depth & Finish	ok					Row 2 31
2	External Relief Dia	4.5 n/c / 5.0 n/c	4.5 n/c	All Rows = 18 n/c ✓			
3	External Relief Depth	✓	5.0 n/c	All Rows = 8 n/c ✓			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		7	2	25		

Inspected By (Sign) & Date

Ravi 7/2/25

Satish 8/2/25

Reviewed by (Engineer-CNC)

Manager-QA