



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.		14322	30/50
2	Machined By		V. T. L. N/A Shop	Dy No. 1.3.0.2.406
3	Pallet Die No.		14177 (3.0) N/A	Rev. No.
4	Die Category	Drg. No.	pertrawide	
5	Out Side Diameter	Drg. No.	620mm, Step on 622.4mm	Tapper 12
6	Inside Diameter	Drg. No.	520.12mm	Step length 13mm
7	Width of Pellet Die	Drg. No.	222mm	Wd external 1.2mm
8	Grooves as per Drawing	Drg. No.	13x2x5mm / 13x2x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A 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 18.0mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 24/2/25	
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				
1	Counter Sinking Depth & Finish	ok		Completed 6 Rev. 38
2	External Relief Dia	3.5mm	Outside (3-3)	Inner
3	External Relief Depth		23mm	20mm
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 24/2/25	

Reviewed by (Engineer-CNC)

Manager-QA