



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.		14364 14364	45/50/6355
2	Machined By		V.T.L. H/c Shop	Dy. Lark 3310
3	Pallet Die No.		14282 (G.O) H/c	
4	Die Category	Drg. No.	Exch. side	
5	Out Side Diameter	Drg. No.	Ø 19.8 H/c ② Step 00, Ø 11.8 H/c Step length 11.5	
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	Tapping H/c of holes 12
14	Tapping On Second Side	Half pitch of 1st side	OK	Back Side
15	Tapping Hole Depth		Drill Depth 20.2 H/c Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 18/3/25	
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		Counter 60
2	External Relief Dia	6.5 H/c	Outside 23-35	Row 23
3	External Relief Depth		11 H/c	Inner 5 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porridge	
6	Material Sent For Hardening On Date		18	23
Inspected By (Sign) & Date			Ravi 18/3/25	

Reviewed by (Engineer-CNC)

Manager-QA