

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

Sl. No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14534	40/40
2	Machined By		V.T.L. N/A Shop	By H. Lark
3	Pallet Die No.		13989 (5.0) H	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H, Step 00.99 H	Step length 7.5
6	Inside Diameter	Drg. No.	420.12 H	
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H 12x8x3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	
12	Tapping PCD		454 H	
13	Tapping Hole Diameter		M20 - Check by H20 Bolt	Tapping No. of holes 8 Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.2 H	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 28/2/25	
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		Counter 60° Row 2 17
2	External Relief Dia	5.5 H	Outside (3-3)	Inner
3	External Relief Depth	5 H	Null	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		28 3 25	
Inspected By (Sign) & Date			Ravi 28/3/25	

Reviewed by (Engineer-CNC)

Manager-QA