



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	Spoclfication	Observations	Remarks
1	Work Order No.		14626	30/40/2009
2	Machined By		V.T.L. n/c Shop	Dy. Ho. Lark 3570
3	Pallet Die No.		14778 (3.0) n/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 n/c Step 002 395 n/c	Step length 4.5
6	Inside Diameter	Drg. No.	320.12 n/c	
7	Width of Pellet Die	Drg. No.	142 n/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 n/c / 15.5 x 7 x 2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping Ho. of holes 8
12	Tapping PCD		355 n/c	Both Side
13	Tapping Hole Diameter		MIS - Check by MIS Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 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 12/4/25	
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	3.5 n/c	Outside (2.2)	Inner
3	External Relief Depth		13 n/c	10 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		12 4 25	
Inspected By (Sign) & Date			Ravi 12/4/25	

Reviewed by (Engineer-CNC)

Manager-QA