



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.		14847	38/52
2	Machined By		V.T.L. n/c Shop	Dry H. Lark 8/10
3	Pallet Die No.		13136(4.0)H	
4	Die Category	Drg. No.	29810	
5	Out Side Diameter	Drg. No.	619.9H Step 00-619.9H Step length 19.5	
6	Inside Diameter	Drg. No.	520.12H	
7	Width of Pellet Die	Drg. No.	186H	
8	Grooves as per Drawing	Drg. No.	13x8x5H 13x8x5H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping H. of Holes 12 Both Side
12	Tapping PCD		565H	
13	Tapping Hole Diameter		H20 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4H Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 26/4/25	
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	4.5H	Outside (2-3)	Inner
3	External Relief Depth		18H	12H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		26 4 25	
Inspected By (Sign) & Date			Ravi 26/4/25	

Reviewed by (Engineer-CNC)

Manager-QA