



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull Road, Yamuna Nagar - 135 001 (Haryana)

9908

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.			
2	Machined By		15040	39/50/6355
3	Pallet Die No.		V.T.L. n/c Shop	Drg. No. Lark 8015
4	Die Category	Drg. No.	14632 (-3.5) mm	
5	Out Side Diameter	Drg. No.	External side	
6	Inside Diameter	Drg. No.	619.9 mm, Step 00, 611.9 mm, Step length 19.0	
7	Width of Pellet Die	Drg. No.	52.14 mm	
8	Grooves as per Drawing	Drg. No.	222 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13 x 8 x 5 mm 13 x 8 x 5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		56.5 mm	[Tapping Holes of 12 Bole side]
14	Tapping On Second Side	Half pitch of 1st side	H202 Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.9 mm Tapping Depth = 18.5 mm	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 20/5/25

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 Go
2	External Relief Dia	4.0 mm	Outside 23-33		Inner			Rev. 25
3	External Relief Depth		18 mm		11 mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Ravi
6	Material Sent For Hardening On Date		20	5	25			

Inspected By (Sign) & Date

Ravi 20/5/25

Satish 20/5/25

Reviewed by (Engineer-CNC)

Manager-QA