



Lark Engineering Company (India) Pvt. Ltd.

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

9926

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		14907	33/40/215
3	Pallet Die No.		V.T.L. n/c Shop	Qy No. Lark 3210
4	Die Category	Drg. No.	15074 (3.0) n/c	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 mm Step 00. 490.9 mm	Step length 12.5
7	Width of Pellet Die	Drg. No.	420.14 mm	
8	Grooves as per Drawing	Drg. No.	1578 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 mm 12 x 8 x 3 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		420.14 mm	
14	Tapping On Second Side	Half pitch of 1st side	420.14 mm Check by 420 Drill	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 18.4 mm Tapping Depth 216.5 mm	
17	Visual Inspection Before Gun Drilling		yes	
Inspected By (Sign) & Date			Ravi 22/5/25	
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		
2	External Relief Dia	3.3 mm	Outside 2-2	Inner
3	External Relief Depth		13 mm	7 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purvace	
6	Material Sent For Hardening On Date		22 5 25	
Inspected By (Sign) & Date			Ravi 22/5/25	

Counter 80
Row 24

22/5/25

Reviewed by (Engineer-CNC)

Manager-QA