



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)

9971

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15123	35/50/6355
2	Machined By		V. G. L. n/c Shop	Dry run - Lark S31D
3	Pallet Die No.		11669 (2.8) n/c	
4	Die Category	Drg. No.	2.8 n/c	
5	Out Side Diameter	Drg. No.	619.9 n/c Step 02. 611.9 n/c	Step 1 n/c 19.5
6	Inside Diameter	Drg. No.	52.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13.8 x 5 n/c / 13.8 x 5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		565 n/c	g holes 212
13	Tapping Hole Diameter		M20, Check by M2 Bolt	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.9 n/c Tapping Depth 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 28/5/25	
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 G
2	External Relief Dia	3.3 n/c	2.25	Inner
3	External Relief Depth	20 n/c	15 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Process	
6	Material Sent For Hardening On Date		28 5 25	
Inspected By (Sign) & Date			Ravi 28/5/25	

Satish 28/5/25

Reviewed by (Engineer-CNC)

Manager-QA