



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.		15497	
2	Machined By		V. T. L. M/c Shop	26/5/2013
3	Pallet Die No.		15296(G.O.)	Dy. M. Lark
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	319.9mm	Step on G11.8mm Step by 19.5
6	Inside Diameter	Drg. No.	520.14mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		42mm	
14	Tapping On Second Side	Half pitch of 1st side	42mm	Check by 42mm Bolt
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 24/7/25	
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	6.5mm	Outside 23-3	Inner 14mm
3	External Relief Depth		20mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		24	7 25
Inspected By (Sign) & Date			Ravi 24/7/25	

Reviewed by (Engineer-CNC)

Manager-QA