



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.			
2	Machined By		15235/	32/40/50
3	Pallet Die No.		V.T.L. H/c Shop	Dry H/c, Lark
4	Die Category	Drg. No.	14656(4.0) H/c	
5	Out Side Diameter	Drg. No.	87.2 mm	
6	Inside Diameter	Drg. No.	619.9 mm	Step 00. G 11.9 mm
7	Width of Pellet Die	Drg. No.	520.14 mm	Step length 19.5
8	Grooves as per Drawing	Drg. No.	222 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	1348x5 mm / 1348x5 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		565 mm	
14	Tapping On Second Side	Half pitch of 1st side	H20: Circle by 20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 mm	Tapping Depth 18.4
17	Visual Inspection Before Gun Drilling		Yes	
Inspected By (Sign) & Date			Ravi 30/7/25	
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	4.5 mm / 5.0 mm	4.5 mm	Row 31
3	External Relief Depth		5.0 mm	All Rows 2 8 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purrace	
6	Material Sent For Hardening On Date		30	7 25
Inspected By (Sign) & Date			Ravi 30/7/25	

Reviewed by (Engineer-CNC)

Manager-QA