



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.		15549	35/50
2	Machined By		V.T.L. n/a Shop	6055
3	Pallet Die No.		15005 (3.5) n/a	Qy H. Lark
4	Die Category	Drg. No.	2 extrude	
5	Out Side Diameter	Drg. No.	619.9 n/a - Step 02. 611.9 n/a	
6	Inside Diameter	Drg. No.	520.14 n/a	Step length. 17.5
7	Width of Pellet Die	Drg. No.	222 n/a	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/a 13x8x5 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	Tapping Ho
12	Tapping PCD		565 n/a	of holes. 12
13	Tapping Hole Diameter		n/a, Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.5 n/a	Tapping Depth 18.9
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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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

Counter. 60

1	Counter Sinking Depth & Finish	ok								Row. 35
2	External Relief Dia	4.0 n/a	OK Side 3.3			Inner				
3	External Relief Depth		18 n/a			15 n/a				
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA