



Lark Engineering Company (India) Pvt. Ltd.

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

10522

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.		15807	39/50 ggs
2	Machined By		V.T.L M/c SHOP	Dry No - Lark Ptd
3	Pallet Die No.		13139 (3.5) mm	
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620 mm Step OD 611.9 mm	Step length 19.5 mm
6	Inside Diameter	Drg. No.	520.14 mm	
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c SHOP	Tapping No. of Hole size 12 Both Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M.20 check by M.20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.5 Tapping Depth 18.4 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 23/8/25	
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	outside	Counter 60°
2	External Relief Dia	4 mm	(3.3)	Power 27
3	External Relief Depth		18 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		23 8 25	
Inspected By (Sign) & Date			Ravi 23/8/25	

Satya 23/8/25

Reviewed by (Engineer-CNC)

Manager-QA