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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.		15786	30/5/2013
2	Machined By		N.T.L. n/c Shop	Dr. H. Lark
3	Pallet Die No.		15009 (4.0) n/c	
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	619.9 mm Step 60	611.9 mm
6	Inside Diameter	Drg. No.	520.14 mm	Step length 17.5
7	Width of Pellet Die	Drg. No.	222	
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		n/c Shop	
12	Tapping PCD		565 mm	Tapping n/c of holes 12
13	Tapping Hole Diameter		4202 Check by 42 Roll	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.5 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/8/25

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							Counter. G2
2	External Relief Dia	4.5 mm	outside (3-3)		Inner				Core B1
3	External Relief Depth		18 mm		14 mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Porrace
6	Material Sent For Hardening On Date		26	8	25				

Inspected By (Sign) & Date

Ravi 28/8/25

Reviewed by (Engineer-CNC)

Manager-QA