



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.		16094	32/50
2	Machined By		V.T.I. M/c Shop	Dry No 2 Lark 810
3	Pallet Die No.		15523 (3.0) 44	
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	619.9 44	Step 2 611.9 44
6	Inside Diameter	Drg. No.	520.14 44	Step length 19.8
7	Width of Pellet Die	Drg. No.	222.6 44	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 44	15.3 x 8 x 5 44
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565 44	
13	Tapping Hole Diameter		M20. Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 2 20.5 44	Tapping depth 2 18.4 44
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 20/9/25	
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 2 60
2	External Relief Dia	2.5 44	20 Side (3-3)	Row = 28
3	External Relief Depth		23 44	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		20 9 25	
Inspected By (Sign) & Date			Ravi 20/9/25	

Reviewed by (Engineer-CNC)

Manager-QA