



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		15999	40/40
2	Machined By		V.T.L M/c Shop	Dry No. 2 Lark 310
3	Pallet Die No.		15088 (4.0) H	Rev. 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9 H	Step OD = 490.9 H
6	Inside Diameter	Drg. No.	420.14 H	Step length = 13.5
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H	12x8x3 H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No. of Holes = 28
12	Tapping PCD		453.9 H	Both Side
13	Tapping Hole Diameter		H20, Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.6 H	Tapping depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi 19/9/25	
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		OK	
			No	

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

1	Counter Sinking Depth & Finish	OK							Counter = 8
2	External Relief Dia	4.5 H	22-25		Inner				Row = 20
3	External Relief Depth	4 H			Nil				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date				19	9	25		

Inspected By (Sign) & Date

			Ravi	19-9-25	
--	--	--	------	---------	--

Reviewed by (Engineer-CNC)

Manager-QA