



Lark Engineering Company (India) Pvt. Ltd.

ILTL Sasbali Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

10712

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16094	33/50
2	Machined By		V.T.I M/c Shop	Dry Ng = 1.5 C 6355
3	Pellet Die No.		15687 (Q.O) ~	Rev. 00
4	Die Category	Drp. No.	Q-12 wide	
5	Out Side Diameter	Drp. No.	619.9 ~ Step OD = 611.9 ~	
6	Inside Diameter	Drp. No.	520.14 ~ / 519.12 ~	Step length = 19.8
7	Width of Pellet Die	Drp. No.	222.7 ~	
8	Grooves as per Drawing	Drp. No.	13-3 ~ 8 ~ 5 ~ / 17-3 ~ 8 ~ 5 ~	
9	Fitting Sizes on CNC Plate	Drp. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No of Holes = 12
12	Tapping PCD		565 ~	Both Side
13	Tapping Hole Diameter		M20 Clock by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 ~	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 23/9/25	
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				Counter = 60
1	Counter Sinking Depth & Finish	OK		Row 2 38
2	External Relief Dia	3.5 ~	Outside 2-3 ~	Inner
3	External Relief Depth		23 ~	17 ~
4	Inspection Done Before Hardening By (Name)		Ravi 23/9/25	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		23 9 25	
Inspected By (Sign) & Date			Ravi 23-9-25	

Reviewed by (Engineer-CNC)

Manager-QA