



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	36/5
2	Machined By		V.T.I M/c Shop	Dry No. 2 Lark 3912
3	Pallet Die No.		15690 (3.0) M	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	619.9 M	Step OD = 619.9 M
6	Inside Diameter	Drg. No.	520.14 M / 519 M	Step length = 19.8 M
7	Width of Pellet Die	Drg. No.	222.7 M	
8	Grooves as per Drawing	Drg. No.	13.8 x 8 x 5 M / 13.3 x 8 x 5 M	
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 = 12
12	Tapping PCD		565 M	Both side
13	Tapping Hole Diameter		M20, Check by M20 B-11	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 M	Tapping depth = 28.4 M
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/9/25

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 260
2	External Relief Dia	3.5 M	20 B-11		Inner			Row 238
3	External Relief Depth		20 M		14 M			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			25	5	25		

Inspected By (Sign) & Date

Ravi 25-5-25

Reviewed by (Engineer-CNC)

Manager-QA