

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)

10758

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16087	3540
2	Machined By		V.T.I. M/c Shop	Dry No 2 Lark 9510
3	Pallet Die No.		13949 (3.5) 44	
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	5mm 44	Step OD = 490.9 mm
6	Inside Diameter	Drg. No.	420.14 mm	Step length 17.5
7	Width of Pellet Die	Drg. No.	182 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm / 12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		4544	of Holes = 8
13	Tapping Hole Diameter		M20, Crack by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.44	Tapping depth 16.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 27/9/25

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 22
2	External Relief Dia	4.0 mm	Outside (2.2)		Inner			
3	External Relief Depth		8 mm		5 mm			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			27	9	25		

Inspected By (Sign) & Date

Ravi 27/9/25

Saty 27/9/25

Reviewed by (Engineer-CNC)

Manager-QA