



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)

10790

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		18091 ✓	36/50
2	Machined By		V.T.I. M/c Shop	Dry No. - Lark 8410
3	Pallet Die No.		15827 (2.0) mm	Rev. 00
4	Die Category	Drg. No.	2-draw side	
5	Out Side Diameter	Drg. No.	62.44 mm	Step OD - 61.9 mm
6	Inside Diameter	Drg. No.	52.14 mm	Step length 19.5
7	Width of Pellet Die	Drg. No.	22.2 mm	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 mm	13 x 8 x 5 mm
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 2
12	Tapping PCD		58.5 mm	Both side
13	Tapping Hole Diameter		42.2	Check by 42 R-11
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.5 mm	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 01/10/25

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 mm	23-25	Inner				Row 2 = 38
3	External Relief Depth	20 mm		14 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			01	10	25		

Inspected By (Sign) & Date

Ravi 01/10/25

Satish 11/10/25

Reviewed by (Engineer-CNC)

Manager-QA