



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)

10860

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16215	40/40
2	Machined By		V.T.I. M/c Shop	Dry No 2 Lark
3	Pallet Die No.		15677 (4.0) M	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9 mm Step OD = 490.9 mm	
6	Inside Diameter	Drg. No.	420.14 mm	Step length = 18.5
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm 12 x 8 x 3 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		454 mm	of Hole = 8
13	Tapping Hole Diameter		M20, Check by M20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.5 Tapping depth = 18.4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 13/10/25	
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 - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter = 60
2	External Relief Dia	4.5 mm	Outside (2.25)	Row = 20
3	External Relief Depth	4 mm	Inner	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		13 10 25	
Inspected By (Sign) & Date			Ravi 13/9/25	

Reviewed by (Engineer-CNC)

Manager-QA