



Lark Engineering Co. (India)
 ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)

Form No. CNC/QA/FM/02

Rev. No. 01

Inprocess Inspection (Pellet Dies)

Rev. Date 31.07.2013

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10766	36/40, 995
2	Machined By		V.T.L. Ula Shop	Dry Hole Lark 3370
3	Pellet Die No.		10724(3.0) mm	
4	Die category	Drg. No.	Senior	
5	Outside diameter	Drg. No.	499.9 mm Step OD, 490.9 mm	Step length = 17.5
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width Of Pellet Die	Drg. No.	158 mm	
8	Grooves As Per Drawing	Drg. No.	12+8+3 mm / 12+8+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. of holes = 8 Both side
12	Tapping PCD		454 mm / 453.9 mm	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.5 mm	Tapping Depth = 17 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 11/12/23

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		Rows 24
2	External Relief Dia.	3.3 mm	Outside / Inner	
3	External Relief Depth		10 mm / 4 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		11/12/23	

Inspected By (Sign) & Date Ravi 11/12/23

Reviewed by (Engineer (CNC))
 11/12/23

Manager-QA