



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

Inprocess Inspection (Pellet Dies)

Form No. CNC/QA/FM/02
Rev. No. 01
Rev. Date 31.07.2013

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10736	40/50 355
2	Machined By		V.T.L. M/C Shop	Dy No. Lark 5510
3	Pellet Die No.		10818 (H.O.)	
4	Die category	Drg. No.	Extra side	
5	Outside diameter	Drg. No.	62mm Step OD, 612mm	Step length 19.5
6	Inside Diameter	Drg. No.	520.12mm	
7	Width Of Pellet Die	Drg. No.	222.1mm	
8	Grooves As Per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
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 Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M20, Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 20.4mm	Tapping Depth, 3.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 11/2/23	
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 - 1 Hole Closed	
Note: Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Low = 31
2	External Relief Dia.	4.3mm	Outside	Inner
3	External Relief Depth	/	14mm	10mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		11/2/23	
Inspected By (Sign) & Date			Ravi 11/2/23	

Reviewed By (Engineer (CNC))
Ravi 11/2/23

Manager-QA