



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13698 ✓	32/40 ✓
2	Machined By		V.T.L. n/c Shop	Signature: Lark Shop
3	Pallet Die No.		12720 (B.S) ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm ✓ Step OD = 491 mm ✓	Step length 17.5
6	Inside Diameter	Drg. No.	42.12 mm ✓	
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		n/c Shop	Tapping n/c of Lark 8 Both Side
12	Tapping PCD		454 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 = 18.2 mm ✓	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 31/1/25	
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	4.0 mm ✓	Outside (2-2)	Inner
3	External Relief Depth		12 mm ✓	8 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		3	25
Inspected By (Sign) & Date			Ravi 31/1/25	

Reviewed by (Engineer-CNC)

Manager-QA