



# 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.		12606	35/50/CC
2	Machined By		V.T.L. N/C Shop	Dry No. 12.0.209
3	Pallet Die No.		12789 (G.O) N/C	Rev. 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7mm Shop	3mm Tappers 8
6	Inside Diameter	Drg. No.	548.12mm	Step length 31mm
7	Width of Pellet Die	Drg. No.	195mm	Undercut 2.5mm
8	Grooves as per Drawing	Drg. No.	32+7+8mm   32+7+8mm	(4+1)mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2mm Deep Back Side
11	Tapping Operator		N/C Shop	Tapping No. of holes 4
12	Tapping PCD		819mm	Back side
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 34mm   Tapping Depth 31.8mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 22/8/24

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 30
2	External Relief Dia	6.5mm   7.0mm	6.5mm	All Rows	7.0mm	All Rows
3	External Relief Depth		31mm		16mm	
4	Inspection Done Before Hardening By (Name)					Ravi
5	Material Sent For Hardening By (Name)					Lark Furnace
6	Material Sent For Hardening On Date		22	8	24	

### Inspected By (Sign) & Date

Ravi 22/8/24

Reviewed by (Engineer-CNC)

Manager-QA