



# 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.		12836	AS per Drg. 61/71
2	Machined By		V.T.L. n/c Shop	Drg. No. L.R.C. 2861
3	Pallet Die No.		13485 (3.5)	Rev 200
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1048 mm Step 002 = 1032 mm	Step length 37
6	Inside Diameter	Drg. No.	900.12 mm / 900.8 mm	Tapper = 3
7	Width of Pellet Die	Drg. No.	374.8 mm	
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 mm / 29.5 x 8 x 12.7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 15 Both Side
12	Tapping PCD		970 mm	
13	Tapping Hole Diameter		M24 - Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 38.5 mm	Tapping Depth = 36.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 4/10/24

1	As per programme no.			2 Slot 38.1 mm width 7.5 mm Deep Both Side
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

Counters 60

1	Counter Sinking Depth & Finish	OK						Row = 59
2	External Relief Dia	4.0 mm	Outside (4-4)	Inner				
3	External Relief Depth		17 mm	10 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		4	10	24			

### Inspected By (Sign) & Date

Ravi 4/10/24

Reviewed by (Engineer-CNC)  
 4/10/24

Manager-QA