



# 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.		13716 ✓	33150 ✓
2	Machined By		V.T.L H/C Shop	Dy No. 1802419
3	Pallet Die No.		12876 (3.0) H/C ✓	Rev. No. ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/C, Step OD = 692 H/C	Step length = 9.5 ✓
6	Inside Diameter	Drg. No.	600.12 H/C ✓	
7	Width of Pellet Die	Drg. No.	222 H/C ✓	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H/C / 12.5 x 8 x 7 H/C ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of Holes = 12 Both side
12	Tapping PCD		645 H/C ✓	
13	Tapping Hole Diameter		H20 - Check by H22 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 22.2 H/C Tapping Depth = 20.5 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 28/12/24

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

Counter = 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.5 H/C	Outside (3-3)		Inner					
3	External Relief Depth		23 H/C		17 H/C					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		28	12	24					

### Inspected By (Sign) & Date

Ravi 28/12/24

Reviewed by (Engineer-CNC)

Manager-QA