



# 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.		13841	42/50
2	Machined By		V.T.L H/C Shop	Dy. No. 6-20-9980
3	Pallet Die No.		13707 (4.0) H/C	Rev. 00
4	Die Category	Drg. No.	Ext. sawide	
5	Out Side Diameter	Drg. No.	619.9 H/C	Step 00, Tapper 12°
6	Inside Diameter	Drg. No.	520.14 H/C	Step length = 18.5
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H/C	Tapping No. of Holes = 12 Both Side
13	Tapping Hole Diameter		H/C - Check by H/C B.L.	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.2 H/C	Tapping Depth = 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 9/1/25

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

Counter = 60  
Raw = 31

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 H/C	Outside (3-3)		Inner		
3	External Relief Depth		12 H/C		8 H/C		
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		9	1	25		

### Inspected By (Sign) & Date

Ravi 9/1/25

Reviewed by (Engineer-CNC)  
Jatso 10/1/25

Manager-QA