



# 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.		13876	33/46
2	Machined By		V. T. L. H/C Shop	Dy. No. 1202832
3	Pallet Die No.		13059(3.0) H/C	Rev. 01
4	Die Category	Drg. No.	58310	
5	Out Side Diameter	Drg. No.	612 H/C Step 02. 624 H/C	Tappan 12
6	Inside Diameter	Drg. No.	520.12 H/C	Step length 12 H/C
7	Width of Pellet Die	Drg. No.	186 H/C	End cut 6 H/C
8	Grooves as per Drawing	Drg. No.	14x8x5 H/C / 14x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H/C	Tapping H/C of Holes. 12 Rota Side
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
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 H/C
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

1	Counter Sinking Depth & Finish	ok							Counter. Go
2	External Relief Dia	3.5 H/C	outside (3-3)		1mm H/C				Rev. 30
3	External Relief Depth		19 H/C		13 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

*Satya* 9/1/25

Reviewed by (Engineer-CNC)

Manager-QA