



# 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.		13755	15/50
2	Machined By		V.T.L M/c Shop	Drg No - Lark Sta
3	Pallet Die No.		13699 (6.0mm)	6355
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	6.20mm	Step od - 6.12mm
6	Inside Diameter	Drg. No.	5.012mm	Step length - 19.5mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[ Tapping No. of Holes 19 Both Side ]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M/c Check by M/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.4mm	Tapping Depth - 18.5mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanpreet Singh 04/11/25

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 - 600

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	6.5mm	outside (3-3)	Inner		
3	External Relief Depth		11mm	5mm		
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		04	1	25	

### Inspected By (Sign) & Date

Ramanpreet Singh 04/11/25

*Signature*  
4/11/25

Reviewed by (Engineer-CNC)

Manager-QA