



# 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.		13805	87/47
2	Machined By		V.T.C n/c Shop	Dry No. 6209 897
3	Pallet Die No.		13697 (3-0) n/c	Rev. no
4	Die Category	Drg. No.	Ext 29 wide	
5	Out Side Diameter	Drg. No.	Ø14 n/c, Step 00, 6Ø15 n/c, Step length 1.5	
6	Inside Diameter	Drg. No.	520.12 n/c	Tappet 12
7	Width of Pellet Die	Drg. No.	222 n/c	Under cut 3.75
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c   13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of Holes 12 Back side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 n/c Tapping Depth 18.6 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 7/1/25

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 60°
2	External Relief Dia	3.5 n/c	Outside (3-3)	Inner				Rev 32
3	External Relief Depth		23 n/c	20 n/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		7	1	25			

### Inspected By (Sign) & Date

Ravi 7/1/25

Reviewed by (Engineer-CNC)

Manager-QA