



# 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

8965  
8970

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		13878	27/47
3	Pallet Die No.		V.T.L. H/c Shop	Qty No. 1.9.0.21397
4	Die Category	Drg. No.	13711 (3.0) H/H	Rev. No.
5	Out Side Diameter	Drg. No.	Feed side	
6	Inside Diameter	Drg. No.	614 H/H, Step OD, 621.5 H/H	Tappet = 12°
7	Width of Pellet Die	Drg. No.	520.12 H/H	Step length = 31.5
8	Grooves as per Drawing	Drg. No.	222 H/H	Under cut = 3.75
9	Fitting Sizes on CNC Plate	Drg. No.	1348 x 5 H/H   1348 x 5 H/H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping H/c of Holes = 12 Both Side
13	Tapping Hole Diameter		565 H/H	
14	Tapping On Second Side	Half pitch of 1st side	H/c Check by H/c Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.2 H/H	Tapping Depth = 12.0 H/H
17	Visual Inspection Before Gun Drilling		yes	
			ok	

### Inspected By (Sign) & Date

1	As per programme no.		Ravi 11/1/25
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 H/H	outside (3-3)	Inner				Rev = 37
3	External Relief Depth		23 H/H	20 H/H				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		11	1	25			
Inspected By (Sign) & Date		Ravi 11/1/25						

Reviewed by (Engineer-CNC) [Signature] 11/1/25

Manager-QA