



# 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.		13981 ✓	26/45 ✓
2	Machined By		V. T. L. N/C Shop	Drg No. 13.02.615
3	Pallet Die No.		13065 (3.0) ✓	Row = 00 ✓
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	61044, Step OD = 623.6 ✓	Tapper = 12 ✓
6	Inside Diameter	Drg. No.	520.2 ✓	Step length ✓
7	Width of Pellet Die	Drg. No.	186 ✓	Lead cut = 6.8 ✓
8	Grooves as per Drawing	Drg. No.	1348 x 3 ✓   1348 x 3 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		565 ✓	
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 ✓	Tapping Depth = 13.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 11/1/25

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 Row = 30
2	External Relief Dia	3.5 ✓	Outside (3-3)		Inner		
3	External Relief Depth		22 ✓		19 ✓		
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)

Manager-QA