



# 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.		13985	43/50
2	Machined By		V.T.L n/c Shop	Drg No. 1.80.685
3	Pallet Die No.		13068(4.0)H	Rev = 00
4	Die Category	Drg. No.	33310	
5	Out Side Diameter	Drg. No.	620 H	Tap hole = 12°
6	Inside Diameter	Drg. No.	520.12 H	Step length = 20 H
7	Width of Pellet Die	Drg. No.	186 H	Under cut = 2 H
8	Grooves as per Drawing	Drg. No.	13x8x3 H   13x8x3 H	
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 H	
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 H Tapping Depth = 18.8 H	
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

Counter = 60

1	Counter Sinking Depth & Finish	ok							Ravi = 25
2	External Relief Dia	U.5 H	outside (3-3)		Inner				
3	External Relief Depth		11 H		7 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)

Manager-QA