



# 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.		13925	43/50	
2	Machined By		V.T.L. n/c Shop	Drg. no. 6.0-980	
3	Pallet Die No.		13719(4.0) n/c	Rev. no.	
4	Die Category	Dr. No.	Perd. inside		
5	Out Side Diameter	Dr. No.	619.8 mm (A) Step 0.2 Tapper 12°		
6	Inside Diameter	Dr. No.	520.3 mm (B)	Step length 18.5 mm	
7	Width of Pellet Die	Dr. No.	222 mm		
8	Grooves as per Drawing	Dr. No.	13x8x5 mm / 13x8x5 mm		
9	Fitting Sizes on CNC Plate	Dr. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		n/c Shop	Tapping etc of holes 12° Back Side	
12	Tapping PCD		565 mm		
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 mm Tapping Depth 212.6 mm		
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Soni 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		
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>					
1	Counter Sinking Depth & Finish	ok		Counters 60°	
2	External Relief Dia	4.5 mm	outside (2-3)	Inner	
3	External Relief Depth		11 mm	7 mm	
4	Inspection Done Before Hardening By (Name)		Soni		
5	Material Sent For Hardening By (Name)		Lark Purvase		
6	Material Sent For Hardening On Date		11	1	25
Inspected By (Sign) & Date			Soni 11/1/25		

Reviewed by (Engineer-CNC) *Soni 13/1/25*

Manager-QA