



# 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.		13830	30/45/70
2	Machined By		V.T.L n/c Shop	Drg No. 13.02277
3	Pallet Die No.		12929(G.O)H	Rev. 03
4	Die Category	Drg. No.	H. Turbo	
5	Out Side Diameter	Drg. No.	688 H, Step 00, 697.8 H	Tapper, 5
6	Inside Diameter	Drg. No.	548.1 H	Step length 38.5
7	Width of Pellet Die	Drg. No.	215 H	Undercut - 1.8 H
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 H   29.5 x 10 x 8 H (G.2) H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[ Face Side Step 1 H Deep Both Side ]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[ Tapping Holes of Holes, 2 Both Side ]
12	Tapping PCD		618 H	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 32 H Tapping Depth 30.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 16/1/25

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, 30 Roz = 14
2	External Relief Dia	6.5 H / 7.0 H	6.5 H	All Rows = 40 H			
3	External Relief Depth		1.0 H	All Rows = 25 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		16	1	25		

### Inspected By (Sign) & Date

Ravi 16/1/25

Reviewed by (Engineer-CNC)

Manager-QA