



# 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.		13988	30/50/
2	Machined By		V.T.L n/c Shop	Drg No. 1.30.578
3	Pallet Die No.		13744(3.0) n/c	Row 20/
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	619.6 n/c Step 002 615.5 n/c	Tapper 4°
6	Inside Diameter	Drg. No.	520.12 n/c	Step length 20 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c   13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of Hole 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		H20 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 n/c	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 20/11/25	
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 - 1 Hole Closed	
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	ok		Counter Boi Row 28
2	External Relief Dia	3.3 n/c	Outside (3.3)	Inner
3	External Relief Depth		23 n/c	20 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		20	25
Inspected By (Sign) & Date			Ravi 20/11/25	

Reviewed by (Engineer-CNC)

Manager-QA