



# 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.		INV ✓	44/50 ✓ 9355
2	Machined By		M.T.C. H/c Shop	Dy. No. Lark 3510
3	Pallet Die No.		13736(4.0) H/c	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	619.9 H/c	Step OD = 611.9 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	Step length = 19.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	Tapping No. of holes = 12 Both Side
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/c	Tapping Depth = 18.6 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 24/7/25

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

Count 212600 Ravi 31

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.3 H/c	Outside (2-3)		Inner		
3	External Relief Depth		14 H/c		6 H/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		24		25		

### Inspected By (Sign) & Date

Ravi 24/7/25

Satish 24/7/25

Reviewed by (Engineer-CNC)

Manager-QA