



# 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.		13983	24/50
2	Machined By		V.T.L. n/c Shop	Dy. No. 1204/25
3	Pallet Die No.		13554(3.0) n/c	Rev 2 of
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c Step 002 698 n/c	Tappers 12
6	Inside Diameter	Drg. No.	300.12 n/c	Step length = 300
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x7 n/c / 12x8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping N. of holes 12 Both side
12	Tapping PCD		340 n/c	
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 n/c	Tapping Depth 13.7 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 27/1/25

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 Sink				Bo	
1	Counter Sinking Depth & Finish	ok					Rev 2 of
2	External Relief Dia	3.5 n/c	Outside (2-3)		Inner		
3	External Relief Depth		22 n/c		16 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		27	1	25		
Inspected By (Sign) & Date		Ravi 27/1/25					

Reviewed by (Engineer-CNC)

Manager-QA