



# 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.		14023	55/55
2	Machined By		V.T.L. H/c Shop	Dy. Insp. (S. C. / 14/24)
3	Pallet Die No.		13585(5.0) H/c	Rev. 00
4	Die Category	Drg. No.	Ext. 29 wide	
5	Out Side Diameter	Drg. No.	630 H/c	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x87.5 H/c   13x87.5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of holes, 12 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.3 H/c	Tapping Depth 18.8 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 30/1/25

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 - Hole Colused

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter Sink
2	External Relief Dia	5.5 H/c	Outside (3-3)	Inner				Rev. 26
3	External Relief Depth		5 H/c	Mill				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Ferrace
6	Material Sent For Hardening On Date		28	1	25			

### Inspected By (Sign) & Date

Ravi 30/1/25

Reviewed by (Engineer-CNC)  
S. C. / 14/24  
30/1/25

Manager-QA