



# 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.		14050	24/30/50
2	Machined By		V.T.L n/c Shop	Dy. No. 28810
3	Pallet Die No.		13830 (4.0) n/c	
4	Die Category	Drg. No.	Getrawside	
5	Out Side Diameter	Drg. No.	619.8 n/c Step OD: 611.8 n/c	Step length 9.5
6	Inside Diameter	Drg. No.	52.12 n/c (Bore Tapper: 0.3 n/c)	
7	Width of Pellet Die	Drg. No.	289 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 Holes: 12 Both Side
12	Tapping PCD		565 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: 20.3 n/c	Tapping Depth: 18.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 31/1/25

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: Ravi 31
2	External Relief Dia	4.5 n/c   5.0 n/c	4.5 n/c	All Rows 2	98 n/c			
3	External Relief Depth		5.0 n/c	All Rows 2	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		31	1	25			

Inspected By (Sign) & Date Ravi 31/1/25

Reviewed by (Engineer-CNC) Sats 31/1/25

Manager-QA