



# 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.		14036	36/55
2	Machined By		V.T.L. n/c. Shop	Dy No. 1.3.02 347
3	Pallet Die No.		13587 (6.0)mm	Rev. no
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	629.9mm Step no. 624mm	Tapper 12°
6	Inside Diameter	Drg. No.	520.12mm (Bore 519.8mm)	Step length 18mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
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		565mm	
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 20.3mm Tapping Depth 18.6mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 31/7/25

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

Counter - 01

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5mm	outside (3-3)		inner				
3	External Relief Depth		25mm		19mm				
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 31/7/25

Reviewed by (Engineer-CNC)   
 Sats 31/7/25

Manager-QA