



# 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.		14011 ✓	30/40/55 ✓
2	Machined By		V. T. L. H/C Shop	Dr. No. 12.02 ✓
3	Pallet Die No.		14101 (4.0) ✓	Rev. No. ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	710 H/C, Step OD = 693.00	Step length = 20.00
6	Inside Diameter	Drg. No.	600.12 H/C	Tapper: 12°
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/C / 12x8x7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	[ Tapping of Holes: 12° Bottom Side ]
12	Tapping PCD		640 H/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 H/C	Tapping Depth: 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 4/2/25

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 - 3 Hole Colused

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

Counter for

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.5 H/C / 5.0 H/C	4.5 H/C	All Rows 2 25 H/C ✓						
3	External Relief Depth		5.0 H/C	All Rows 15 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		4	25						

**Inspected By (Sign) & Date**

Ravi 4/2/25

Sasouli 5/2/25

Reviewed by (Engineer-CNC)

Manager-QA