



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		14253 ✓	39/50 ✓
2	Machined By		V.T.L. n/c Shop	Digital 1.200980
3	Pallet Die No.		14035(3.5) ✓	Rev 2.00
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	620 ✓	Step OD = Tapper 12°
6	Inside Diameter	Drg. No.	520.12 ✓	(Bor Tapper 12°) Step length 18.5 ✓
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 ✓   13x8x5 ✓	
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 Back Side
12	Tapping PCD		565 ✓	
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 ✓	Tapping Depth 18.0 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 10/2/25

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

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

1	Counter Sinking Depth & Finish	ok						Counter = 60°
2	External Relief Dia	3.8 ✓	outside 2.3-3		inner			Rev 2.35
3	External Relief Depth		18 ✓		11 ✓			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		10	2	25			

### Inspected By (Sign) & Date

Ravi 10/2/25

Ravi 11/2/25

Reviewed by (Engineer-CNC)

Manager-QA