



# 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.			
2	Machined By		14119 ✓	33/50 ✓
3	Pallet Die No.		V. T. L. H/c Shop	Digital Lark 3310
4	Die Category	Drg. No.	13565 (3.0) H/c	
5	Out Side Diameter	Drg. No.	500 H/c	
6	Inside Diameter	Drg. No.	Step 002 491 H/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	420.12 H/c (Box = Tapped 0.3) ✓	
8	Grooves as per Drawing	Drg. No.	180 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/c   12x8x3 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping H/c of holes 8 Both Side
13	Tapping Hole Diameter		454 H/c ✓	
14	Tapping On Second Side	Half pitch of 1st side	H202 Check by H22 Bolt ✓	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 18.3 H/c Tapping Depth 18.9 H/c	
17	Visual Inspection Before Gun Drilling		yes ok	

### Inspected By (Sign) & Date

Ravi 13/12/25

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 20
2	External Relief Dia	3.5 H/c	outside (2-2)		inner			low 30
3	External Relief Depth		13 H/c		7 H/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porroce.
6	Material Sent For Hardening On Date			13	2	25		

### Inspected By (Sign) & Date

Ravi 13/12/25

Reviewed by (Engineer-CNC)  
Santosh 13/12/25

Manager-QA