



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

91634

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.		14081 ✓	57/57 ✓
2	Machined By		V. T. L. n/c Shop	Drill Hole 12.0 mm
3	Pallet Die No.		13863 (B.O) n/c ✓	Revised ✓
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	644 n/c ✓	Step OD: 631.8 n/c ✓
6	Inside Diameter	Drg. No.	530.12 n/c ✓	Step length 17.5 mm
7	Width of Pellet Die	Drg. No.	278 n/c ✓	Lead in cot = 19 n/c ✓
8	Grooves as per Drawing	Drg. No.	43 + 8 + 8 n/c ✓	27 + 2 + 8 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: 8
12	Tapping PCD		594 n/c ✓	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and	Third side One
15	Tapping Hole Depth		Drill Depth: 25.3 mm	Tapping Depth: 23.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 11/2/25

1	As per programme no.		_____	1 Slot 29.1 mm width 18 mm Deep
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

Counters 60°  
Row: 42

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	—	—	N/A	Retief		
3	External Relief Depth						
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Porcane			
6	Material Sent For Hardening On Date			11	2	25	

### Inspected By (Sign) & Date

Ravi 11/2/25

Satish 11/2/25

Reviewed by (Engineer-CNC)

Manager-QA