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# 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.		14124	40/55 ✓
2	Machined By		V.T.L. N/C Shop	Dy. No. 13.02.839
3	Pallet Die No.		13588(6.0) ✓	20020 ✓
4	Die Category	Drg. No.	Ext rawide	
5	Out Side Diameter	Drg. No.	630mm, Step OD: 624mm	Tapper = 12°
6	Inside Diameter	Drg. No.	520.12 mm (Bot Tapper = 0.3mm)	Step length = 28mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
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 10 Both Side
12	Tapping PCD		565 mm	
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 20.3mm	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Sasi 13/2/25

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

Counter 60  
Row 23

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	6.5 mm	Outside (3-3)	Inner		
3	External Relief Depth		2 mm	15 mm		
4	Inspection Done Before Hardening By (Name)		Sasi			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		13	2	25	

### Inspected By (Sign) & Date

Sasi 13/2/25

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Reviewed by (Engineer-CNC)

Manager-QA