



# 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.		14092 ✓	98/38/66
2	Machined By		N.T.L n/c Shop	Dr. No. 1.3.0.609
3	Pallet Die No.		14393 (B.O) ✓	Len 03
4	Die Category	Drg. No.	M. Jambu	
5	Out Side Diameter	Drg. No.	680.7 mm Step 002 892.6 mm	Tabber: 8°
6	Inside Diameter	Drg. No.	546.12 mm (Bar: 548.4 mm)	Step length: 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Undercut: 2.5 mm
8	Grooves as per Drawing	Drg. No.	32.799.2 mm   32.779.2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 mm Deep Bottom Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of Holes: 2 Bottom Side
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 33.2 mm Tapping Depth: 31.0 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 21/7/25

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						Counters: 30° Len: 12
2	External Relief Dia	6.5 mm   7.0 mm	6.5 mm All Rows = 38 mm					
3	External Relief Depth		7.0 mm All Rows = 28 mm					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		21	2	25			

### Inspected By (Sign) & Date

Ravi: 21/7/25

Reviewed by (Engineer-CNC)

Manager-QA