



# 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.		14217 ✓	39/60
2	Machined By		V.T.L. n/c Shop	Drg. No. 13.02111
3	Pallet Die No.		14059(3.0) n/c	Rec. 00 ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 n/c	Step 002 791.8 n/c
6	Inside Diameter	Drg. No.	660.12 n/c	Step length 26.5
7	Width of Pellet Die	Drg. No.	324 n/c	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 n/c	21.5 x 8 x 8 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		725 n/c	Tapping No. of Holes 12 Both Side
13	Tapping Hole Diameter		M22 Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 31.2 n/c	Tapping Depth 29.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Raw: 7/3/25

1	As per programme no.			2 slot 32.1 n/c both side 8 n/c Back Both Side
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°  
Raw: 57

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.8 n/c	Outside (3-3)		Inner			
3	External Relief Depth		27 n/c		21 n/c			
4	Inspection Done Before Hardening By (Name)			Raw: ✓				
5	Material Sent For Hardening By (Name)			Lark Porrace				
6	Material Sent For Hardening On Date			7	3	25		

### Inspected By (Sign) & Date

Raw: 7/3/25

Satya 7/3/25

Reviewed by (Engineer-CNC)

Manager-QA