



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14323 ✓	35/55 ✓
2	Machined By		V.T.L. M/c Shop	Drg No. 13.02.157
3	Pallet Die No.		14563 (3.8) ✓	Rev. 00 ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770 mm	Step length 25 mm
6	Inside Diameter	Drg. No.	660.12 mm	Undercut = 15 mm
7	Width of Pellet Die	Drg. No.	316 mm ✓	
8	Grooves as per Drawing	Drg. No.		
9	Fitting Sizes on CNC Plate	Drg. No.	20x8.7.5 mm   20x8.7.5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		775 mm	Tapping Holes of holes = 12 Both side
13	Tapping Hole Diameter		M20.2 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 25.2 mm	Tapping Depth = 33.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/3/25

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 - 1 Hole. Colored (A)

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter 60  
Low = 48

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.3 mm	outside (3-3)		Inner		
3	External Relief Depth		24 mm		20 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		8	3	25		

Inspected By (Sign) & Date

Ravi 8/3/25

Reviewed by (Engineer-CNC)  
8/3/25

Manager-QA