



# 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.		14280 ✓	38/42/60 ✓
2	Machined By		V.T.L. N/C Shop	Drg. No. 1.3.0.654
3	Pallet Die No.		14149 (6.0) H/H ✓	Reo. 100 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	720 H/H, Step 002 692 H/H	Step length 9.5
6	Inside Diameter	Drg. No.	600.12 H/H	
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	36 x 10 x 7 H/H   36 x 10 x 7 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping P.C.D. of hole 12 Bolt Side
12	Tapping PCD		645 H/H ✓	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/H	Tapping Depth 8.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 7/3/25

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

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

1	Counter Sinking Depth & Finish	OK					Counter Sink Reo = 16
2	External Relief Dia	6.5 H/H   7.0 H/H	6.5 H/H	All Rows = 22 H/H ✓			
3	External Relief Depth		7.0 H/H	All Rows = 12 H/H ✓			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Porrace			
6	Material Sent For Hardening On Date			7	3	25	

Inspected By (Sign) & Date Ravi 7/3/25

Satya  
7/3/25  
Reviewed by (Engineer-CNC)

Manager-QA