



# 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)

9393

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14303 ✓	42/55 ✓
2	Machined By		V.T.L. n/c Shop	Digital U.S.D. 407
3	Pallet Die No.		14124 (G.O) ✓	Rev. 00 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	709.5 mm ✓	Step 002-692.7 mm ✓
6	Inside Diameter	Drg. No.	600.12 mm ✓	Tappet 2 ✓
7	Width of Pellet Die	Drg. No.	222 mm ✓	Step length ✓
8	Grooves as per Drawing	Drg. No.	12x8x7 mm / 12x8x7 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping of holes 12 Both Side
12	Tapping PCD		640 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 20.2 mm ✓	Tapping Depth 18.6 mm ✓
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

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

1	Counter Sinking Depth & Finish	ok							Counters 60
2	External Relief Dia	6.75 mm	outside (2-3)		inner				Counters 23
3	External Relief Depth		19 mm		13 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)

Manager-QA