



# 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.		14149 ✓	60/60
2	Machined By		V. T. L H/C Shop	Drill Nos. 1.2.0.1.50
3	Pallet Die No.		14665 (3.0) H/C	Rev. 100 ✓
4	Die Category	Drg. No.	Yumbo (A31)	
5	Out Side Diameter	Drg. No.	750 H/C Step OD = 743.5 H/C	Step length = 0.3 H/C
6	Inside Diameter	Drg. No.	630.12 H/C / 630.2 H/C ⊕	Tappers 10°
7	Width of Pellet Die	Drg. No.	265 H/C	
8	Grooves as per Drawing	Drg. No.	15x8x5 H/C / 15x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of Holes 16 Both Side
12	Tapping PCD		685 H/C ✓	
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 = 2 H/C	Tapping Depth = 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Sao! 6/3/25

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 - 5 Hole Colused ⊕

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

Counters = 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	—	—	—	—	—	—	—	—
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

### Inspected By (Sign) & Date

Sao! 6/3/25

Reviewed by (Engineer-CNC)

Manager-QA