



# 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)

9355

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12976 ✓	55/55 ✓
2	Machined By		V. T. L. H/C Shop	Drg No. 1-2-02407
3	Pallet Die No.		13484 (4.0) H/C	Rev 200
4	Die Category	Drg. No.	H. Tumb	
5	Out Side Diameter	Drg. No.	709.9 H/C Step OD. 692.8 H/C	Tapper 12°
6	Inside Diameter	Drg. No.	600.12 H/C	Step length 12 H/C
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/C / 12x8x7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	[ Tapping size of holes 12 Beta side ]
12	Tapping PCD		640 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 20.2 H/C	Tapping Dept 13.6 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 11/3/25

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 Colused

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

Counter 60°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.5 H/C	outside (3-3)		Inner					
3	External Relief Depth	/	5 H/C		Mill					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date				11	3	25			

### Inspected By (Sign) & Date

Ravi 11/3/25

Satyam 11/3/25

Reviewed by (Engineer-CNC)

Manager-QA