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# 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. | | 14271 | 31/39/43 |
| 2 | Machined By | | V.T.L M/C Shop | Dg No. 18.0.876 |
| 3 | Pallet Die No. | | 11777 (3.0) MM | Rev. 01 |
| 4 | Die Category | Drg. No. | Extra wide | |
| 5 | Out Side Diameter | Drg. No. | 606 MM, Step OD. 648 MM | Step length. 29 MM |
| 6 | Inside Diameter | Drg. No. | 520.12 MM | Tapper 10° |
| 7 | Width of Pellet Die | Drg. No. | 238 MM | ~~Step length~~ |
| 8 | Grooves as per Drawing | Drg. No. | 20x10x4 MM / 20x10x4 MM | Under cut. 18 MM |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | M/C Shop | |
| 12 | Tapping PCD | | 590 MM | Tapping No of Holes 8 Both Side |
| 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. 28.2 MM Tapping Depth 26.5 | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |
| | **Inspected By (Sign) & Date** | | Ravi 12/3/25 | Final fitting Size Dg No 18.0.876 Rev 02 |
| 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

Counter. 60° Row. 37

| | | | | |
|---|---|---|---|---|
| 1 | Counter Sinking Depth & Finish | ok | | |
| 2 | External Relief Dia | 3.5 MM / 4.0 MM | 3.5 MM All Rows = 18 MM<br>4.0 MM All Rows = 9 MM | |
| 3 | External Relief Depth | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | |
| 6 | Material Sent For Hardening On Date | | 12 / 3 / 25 | |
| | **Inspected By (Sign) & Date** | | Ravi 12/3/25 | |

Satya 12/3/25
Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner