



**Lark Engineering Co. (India)**  
ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)

Form No. CNC/QA/EM/02

Rev. No. 01

**Inprocess Inspection (Pellet Dies)**

Rev. Date 31.07.2013

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10892	23/33/66
2	Machined By		V. T. L. n/c Shop	Dwg No. 15.0.619
3	Pellet Die No.		11118 (G.O) n/c	Rev. 01
4	Die category	Drg. No.	M. Jumbo	
5	Outside diameter	Drg. No.	680.69 n/c Shop OD. 679.3 n/c	Tapper 28°
6	Inside Diameter	Drg. No.	548.12 n/c	Shop length 31 n/c
7	Width Of Pellet Die	Drg. No.	195 n/c	Under cut 2.5 n/c
8	Grooves As Per Drawing	Drg. No.	32x7x8 n/c / 32x7x8 n/c	(4x8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side 3rd gear
10	Drilling Area Surface Smoothness		ok	Back both side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	Tapping No
13	Tapping Hole Diameter		M16, Check by M16 Bolt	of holes, 4
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 n/c	Tapping Depth 31.8 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 11/2/23	
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	
<b>Note:</b> Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok	_____	Coanded 30° Rev = 12
2	External Relief Dia.	6.5 n/c / 7.0 n/c	6.5 n/c All Cines / 7.0 n/c All Cines	
3	External Relief Depth	_____	43 n/c / 33 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		11/2/23	
Inspected By (Sign) & Date			Ravi 11/2/23	

*Ravi*  
11/2/23

Reviewed by (Engineer (CNC))

Manager-QA