



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

Form No. CNC/QA/FM/02

Rev. No. 01

**Inprocess Inspection (Pellet Dies)**

Rev. Date 31.07.2013

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10562 ✓	33/50 ✓
2	Machined By		V.T.L H/c Shop	Drg. No. 1.8.0, 450
3	Pellet Die No.		10783 (3.0) H/c ✓	Rev. No. ✓
4	Die category	Drg. No.	J&W	
5	Outside diameter	Drg. No.	730 H/c, Step cut = 743.4 H/c	Taper = 10°
6	Inside Diameter	Drg. No.	630.12 H/c	Step length = 23 ✓
7	Width Of Pellet Die	Drg. No.	290 H/c	Under cut = 6.7 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	Tapping Hole of Hole = 16 Both Side
11	Tapping Operator		H/c Shop	
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 = 20.4 H/c	Tapping Depth = 13.8 ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 4/12/23	
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: Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	OK		Rev. 2-52
2	External Relief Dia.	3.3 H/c	Outside / Inner	
3	External Relief Depth		23 H/c / 17 H/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		4/12/23	
Inspected By (Sign) & Date			Ravi 4/12/23	

Reviewed by (Engineer (CNC))  
  
 4/12/23

Manager-QA