



**Lark Engineering Co. (India)**  
 ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (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.		10859 ✓	36/40 ✓
2	Machined By		V.T.L. H/c Shop	Drg No. 62.02 5062
3	Pellet Die No.		10097 (4.0) H/c ✓	Rev = 00 ✓
4	Die category	Drg. No.	Senior ✓	
5	Outside diameter	Drg. No.	500 H/c ✓ Step 00	Tapper 12
6	Inside Diameter	Drg. No.	430.12 H/c ✓	Step length 13.5 H/c ✓
7	Width Of Pellet Die	Drg. No.	158 H/c ✓	
8	Grooves As Per Drawing	Drg. No.	12.4 x 8 + 3 H/c   12.4 x 8 + 3 H/c (R. 12 + 8 + 3)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes, 8 Both Side
12	Tapping PCD		454 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 Rep. 19. H/c	Tapping Depth = 17 H/c
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:</b> Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Recess 2
2	External Relief Dia.	4.5 H/c ✓	92-side	Inner
3	External Relief Depth		8 H/c ✓	4 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))  
*[Signature]*  
 4/12/23

Manager-QA