



**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.		10563	26/50
2	Machined By		V.T.L. n/c Shop	Drg No. 1.3.0 2450
3	Pallet Die No.		10784 (4.0) n/c	Rev. 00
4	Die Category	Drg. No.	J&O	
5	Out Side Diameter	Drg. No.	730 n/c / Step 00, 743.3 n/c	Tapper 1.0"
6	Inside Diameter	Drg. No.	630.12 n/c	Step length 23
7	Width of Pellet Die	Drg. No.	290 n/c	Under cut 6.25
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c   15x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes = 16 Both Side
12	Tapping PCD		685 n/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 81 n/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 2/3/24

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

1	Counter Sinking Depth & Finish	ok					Counter 60° Ravi 243
2	External Relief Dia	4.5 n/c	20 Side (2-3)	Inner			
3	External Relief Depth		18 n/c	14 n/c			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark For trace
6	Material Sent For Hardening On Date		2	3	24		
Inspected By (Sign) & Date		<u>Ravi 2/3/24</u>					

Reviewed by (Engineer-CNC)

Manager-QA