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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.		13939 ✓	50/50 ✓
2	Machined By		V. T. L n/c Shop	Dy. No. 13760
3	Pallet Die No.		14250 (8.0) n/c	Rev 2.00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9 n/c	Step OD = 491 n/c
6	Inside Diameter	Drg. No.	420.12 n/c	Step length = 13.5
7	Width of Pellet Die	Drg. No.	158 n/c ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c / 12 x 8 x 3 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 = 8 U Hole Side
12	Tapping PCD		454 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 = 18.2 n/c	Tapping Depth = 16.6 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/11/25

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

Count as per

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	8.5 n/c	Outside (2-2)		Inner					
3	External Relief Depth		4 n/c		Nil					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date		27		1		25			

Inspected By (Sign) & Date

Ravi 27/11/25

Satish 27/11/25
Reviewed by (Engineer-CNC)

Manager-QA