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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14074 /	39/50
2	Machined By		V.T.L. H/c Shop	355
3	Pallet Die No.		13834 (3-5)mm	3510
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	619.9mm, Step 002 611.9mm	Step length 19.5
6	Inside Diameter	Drg. No.	520.12mm (Ber Tapper 6.3mm) (A)	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565mm	Tapping No. of Holes = 12 Both Side
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 20.3mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/2/25

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 - 1 Hole Colused (A)

Note : Mark the defective holes/missed holes with the help of Permanent Marker

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1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0mm	Outside (3-3)	Inner					
3	External Relief Depth		18mm	11mm					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		1	2	25				

Inspected By (Sign) & Date

Ravi 11/2/25

Satya 11/2/25

Reviewed by (Engineer-CNC)

Manager-QA