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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.		14115	45/50
2	Machined By		V.T.L. H/c Shop	Drill 18.0 370
3	Pallet Die No.		14253 (G.O) H/c	Row 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.8 H/c Step OD 491 H/c	Step length 17 H/c
6	Inside Diameter	Drg. No.	420.12 H/c	17.5 H/c
7	Width of Pellet Die	Drg. No.	159.5 H/c	
8	Grooves as per Drawing	Drg. No.	13.5 x 8 x 3 H/c 12 x 8 x 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	[Tapping No of holes = 8 Both Side]
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 H/c Tapping Depth 16.4 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/2/25

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

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

Counter 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	Ø.5 H/c	Outside (2-2)		Inner					
3	External Relief Depth		11 H/c		5 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		3	2	25					

Inspected By (Sign) & Date

Ravi 31/2/25

Satyam 31/2/25

Reviewed by (Engineer-CNC)

Manager-QA