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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.		14046 ✓	22/45 ✓
2	Machined By		V.T.L. n/c Shop	Dry size 13.02 ✓
3	Pallet Die No.		13831(2.8) ✓	Rev 2 ✓
4	Die Category	Drg. No.	Ext. inside	②
5	Out Side Diameter	Drg. No.	610 ✓ / Step 002 622 ✓	4 ✓ Tapped 12 ✓
6	Inside Diameter	Drg. No.	520.12 ✓	Step length 218 ✓
7	Width of Pellet Die	Drg. No.	222 ✓	Under cut 6.2 ✓
8	Grooves as per Drawing	Drg. No.	13x8x5 ✓ / 13x8x5 ✓	
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 12 Back Side
12	Tapping PCD		565 ✓	
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 20.3 ✓	Tapping Depth 18.5 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/2/25

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 - 5 Hole Closed ②

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	3.3 ✓	Outside (2-3)		Inner				
3	External Relief Depth		25 ✓		22 ✓				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Pinnacle
6	Material Sent For Hardening On Date			6	2	25			

Inspected By (Sign) & Date

Ravi 6/2/25

Reviewed by (Engineer-CNC)
Sats 6/2/25

Manager-QA