



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)

9162

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|-------------------------------------|--|
| 1 | Work Order No. | | 14131 | 30/66 |
| 2 | Machined By | | V.T.L. N/C Shop | Digital 12.0 = 330 |
| 3 | Pallet Die No. | | 14023(6.0) N/C | 1002 08 |
| 4 | Die Category | Drg. No. | M. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 680.1 N/C / Step 05, 6931 N/C | Tapper, 8" |
| 6 | Inside Diameter | Drg. No. | 546.12 N/C (Part 548.1) | Step length = 81 N/C |
| 7 | Width of Pellet Die | Drg. No. | 195 N/C | Undercut = 3.8 N/C |
| 8 | Grooves as per Drawing | Drg. No. | 32 x 7 x 9.1 N/C 32 x 7 x 9.1 N/C | (4 x 8) |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | [Face side side 2 x 1/4 Deep Side] |
| 11 | Tapping Operator | | N/C Shop | |
| 12 | Tapping PCD | | 619 N/C | [Tapping Holes of holes 2 Back Side] |
| 13 | Tapping Hole Diameter | | N/C Check by N/C Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth 33.4 N/C | Tapping Depth 31.6 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 11/8/25

| | | | | |
|---|--------------------------------|--------|-------|------------------|
| 1 | As per programme no. | | _____ | Final Size |
| 2 | Gun Drilling Work Completed On | | _____ | As Per |
| 3 | Hole Finish In Gun Drilling | Marked | ok | LSD - 609 Rev 03 |
| 4 | Defective Holes (If Any) | | No | _____ |

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

Counter 20

| | | | | | | | | | | |
|---|--|---------|--------------|---|----|--|--|--|--|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | | |
| 2 | External Relief Dia | 1.0 N/C | All Rows | | | | | | | |
| 3 | External Relief Depth | | 36 N/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 | | 11 | 2 | 25 | | | | | |

Inspected By (Sign) & Date

Ravi 11/8/25

Reviewed by (Engineer-CNC)

Manager-QA