



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)

9160

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14042	50/66
2	Machined By		N.T.L. n/c Shop	52/66
3	Pallet Die No.		14029(10.0)M4	Dy No. 12.02330
4	Die Category	Drg. No.	N. Jumbo	Rev. 08
5	Out Side Diameter	Drg. No.	680.1 M4	Step 00: 692.8 M4
6	Inside Diameter	Drg. No.	548.12 M4	Step length 31 M4
7	Width of Pellet Die	Drg. No.	195 M4	Wden cut = 2.3 M4
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 M4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 M4	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.3 M4	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 12/01/25

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

1	Counter Sinking Depth & Finish	ok								Counter 30
2	External Relief Dia	11.0 M4	1st Pass	12nd Pass						Row: 8
3	External Relief Depth		16 M4	14 M4						
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		18	2	25					

Inspected By (Sign) & Date

Ravi 12/01/25

Reviewed by (Engineer-CNC)

Manager-QA